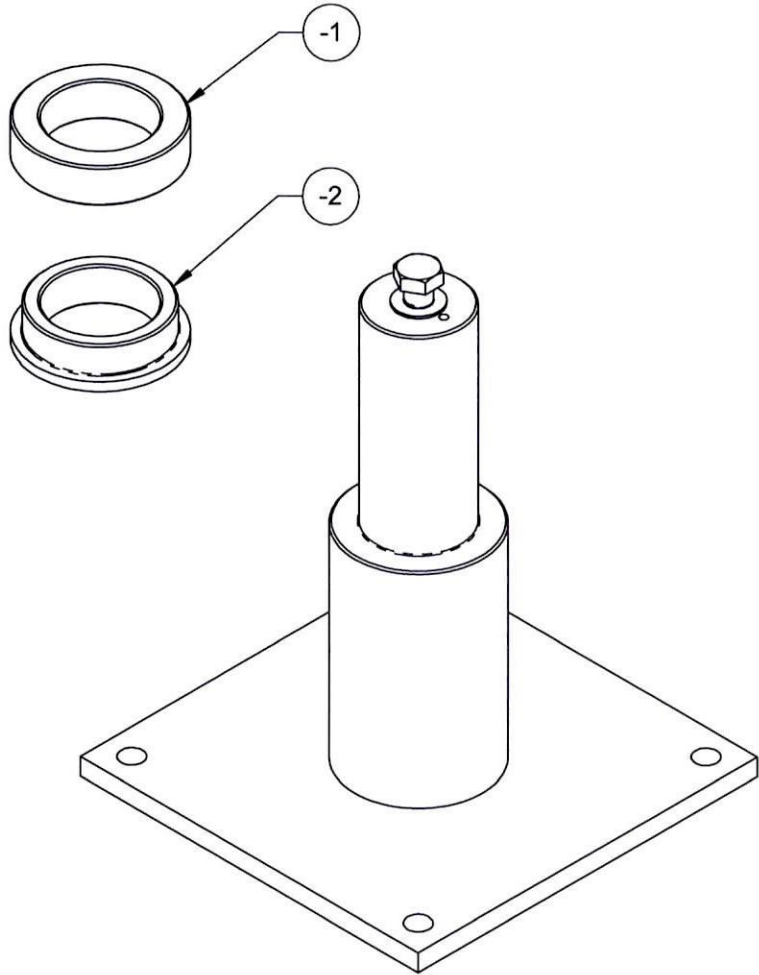
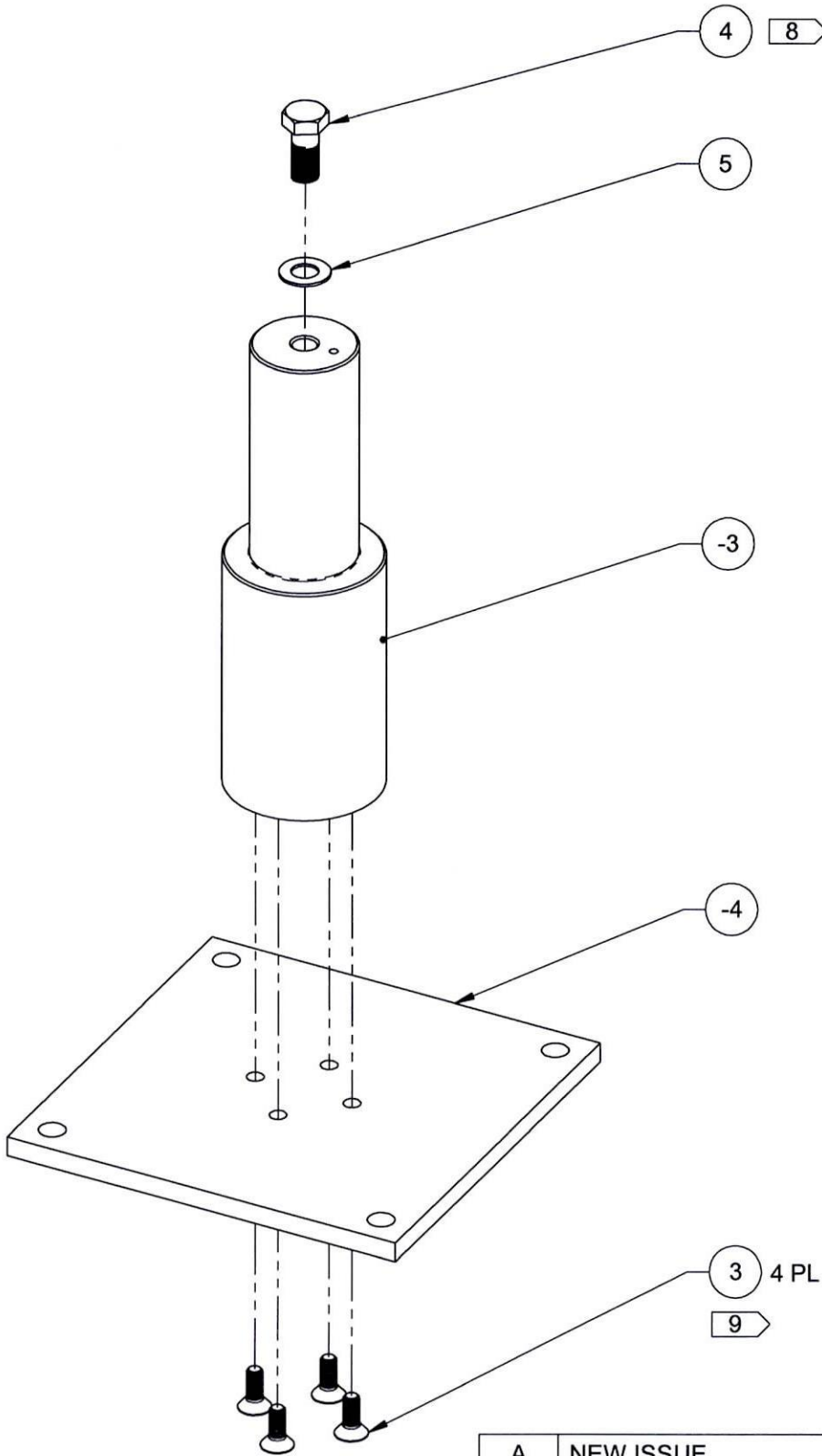


ITEM #	QTY	PART #	PART TITLE
-1	1	RBT18649-1-1	SLEEVE A
-2	1	RBT18649-1-2	SLEEVE B
-3	1	RBT18649-1-3	SUPPORT
-4	1	RBT18649-1-4	BASE
5	4	McMaster#93791A424	3/8"-16 X 1" LG. SS FLAT HEAD SCREW
6	1	AN10-12A	5/8"-18 X 1.4 LG HEX HEAD BOLT
7	1	NAS1149F1063P	5/8" WASHER

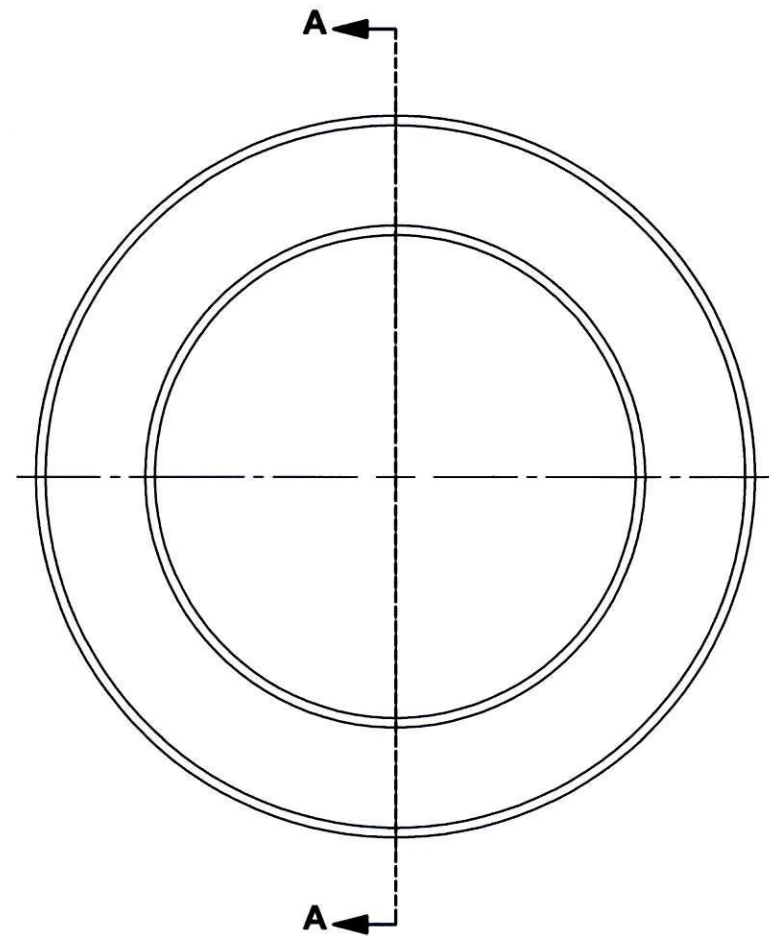
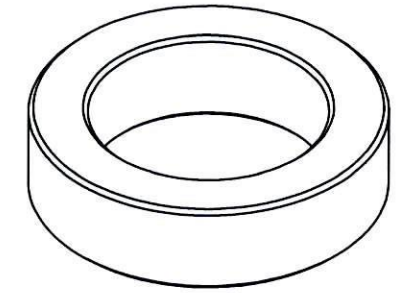


RB18649-1 WORKAID ITEM #1

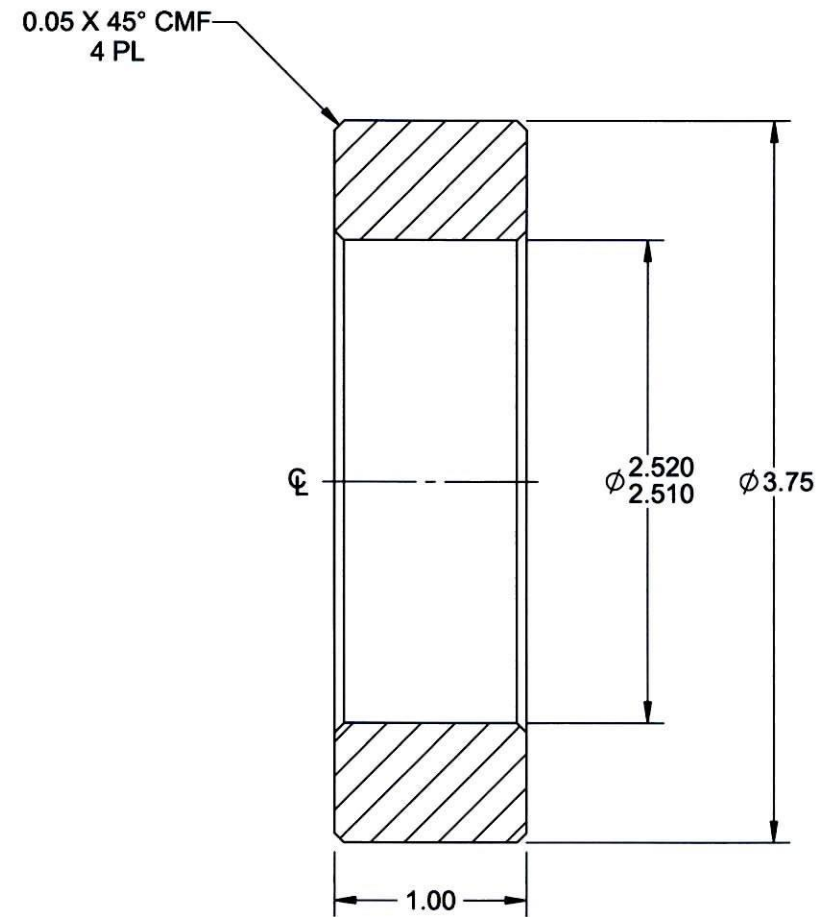
NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) INSTALL HAND TIGHT
9) TORQUE FASTENERS 160 - 185 IN-LBS



A	NEW ISSUE	18-713	KT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 1 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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RB18649-1-1 SLEEVE A

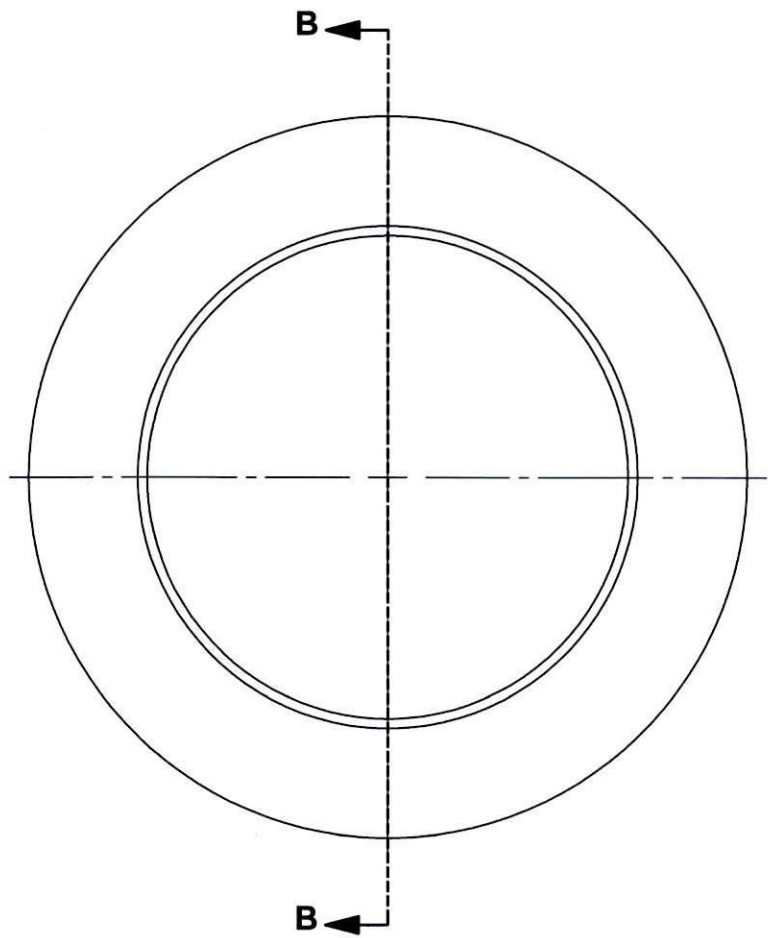


SECTION A-A

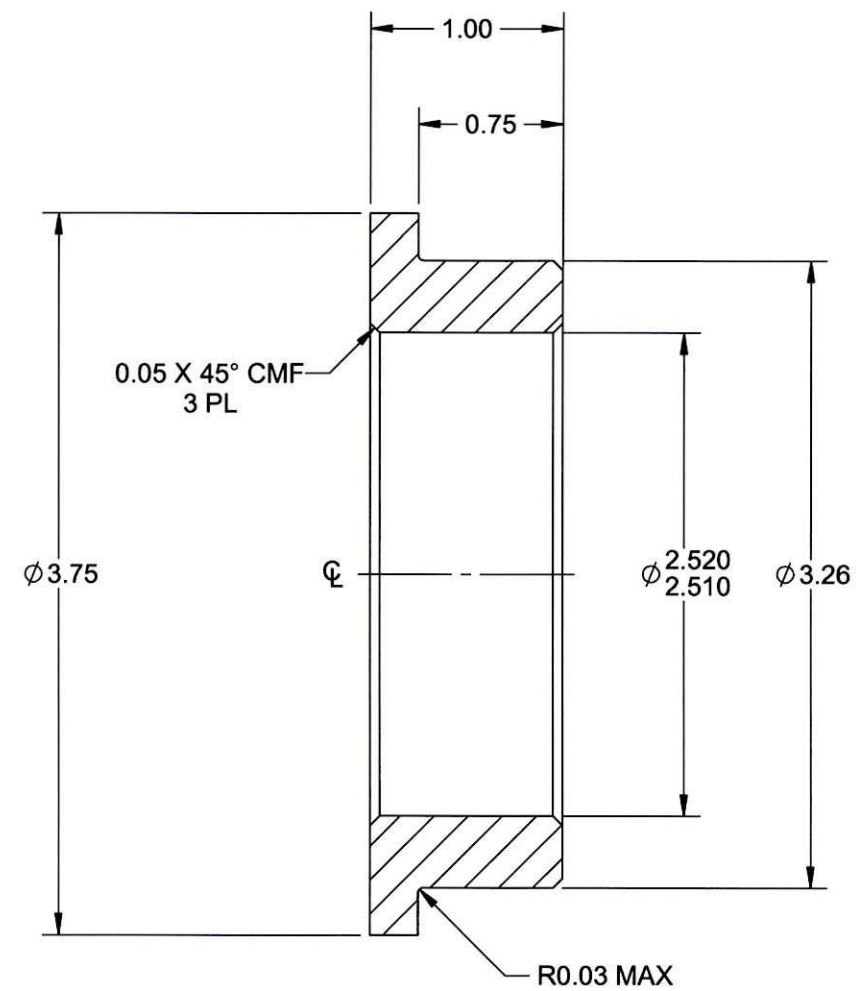
NOTES:

- NOTES:
- 1) MATERIAL: NYLON 6 (WHITE OR BLACK)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

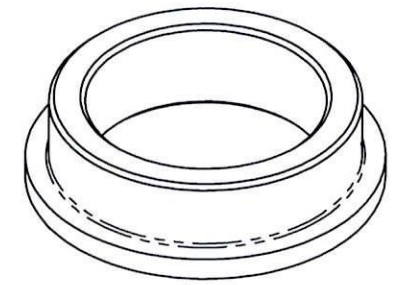
DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 2 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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RB18649-1-2 SLEEVE B



SECTION B-B

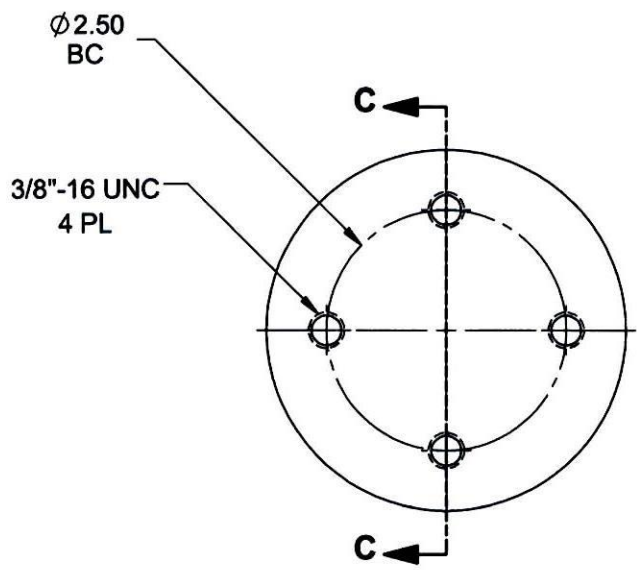
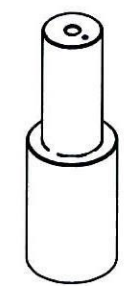


NOTES:
1) MATERIAL: NYLON 6 (WHITE OR BLACK)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

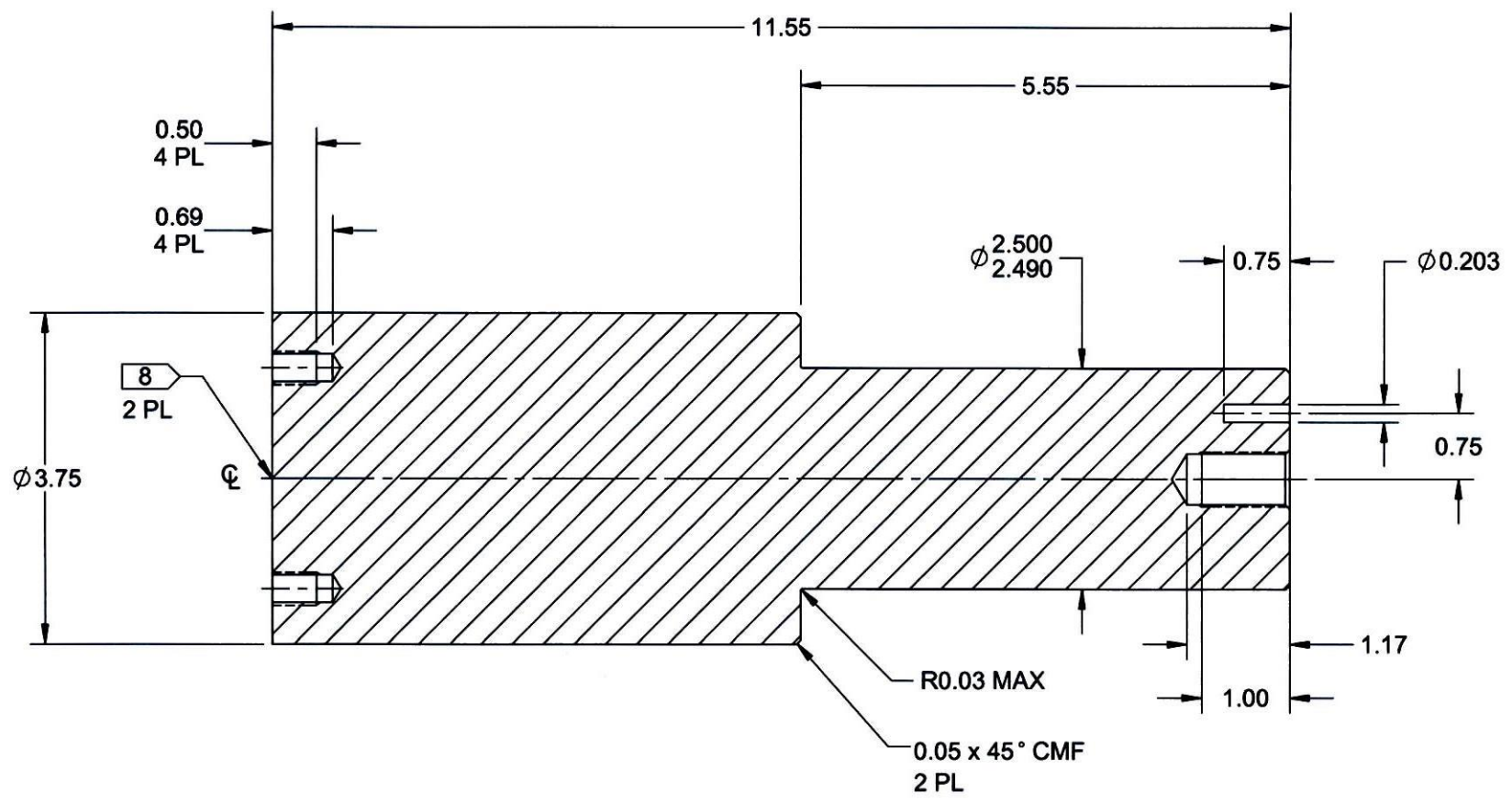
DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 3 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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D
C
B
A

D
C
B
A



RBT18649-1-3 SUPPORT



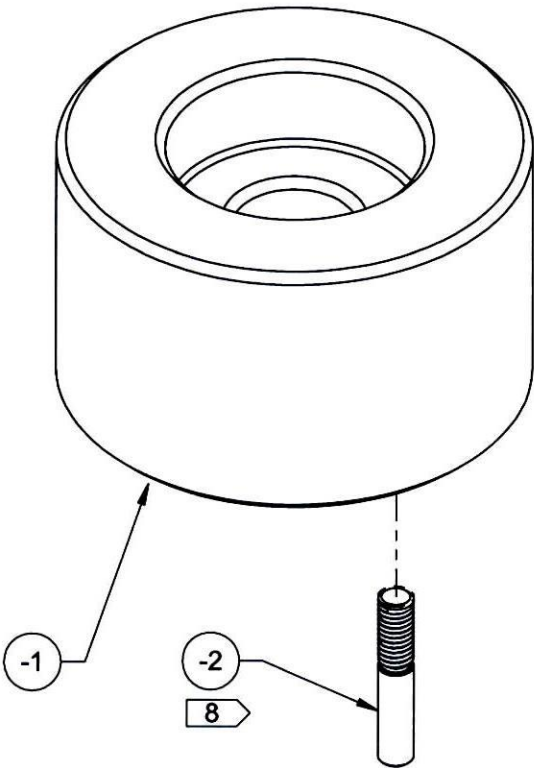
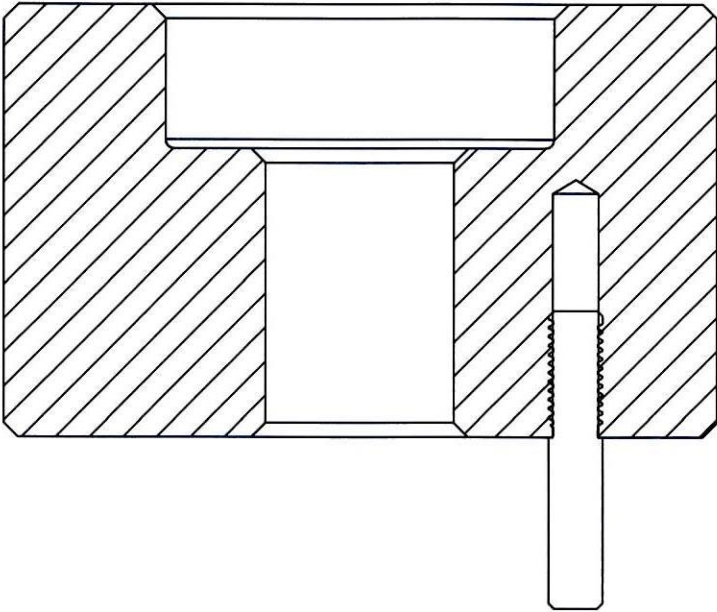
SECTION C-C

- NOTES:
- 1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A
 - 8) CENTER DRILL IS ACCEPTABLE

ML

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 4 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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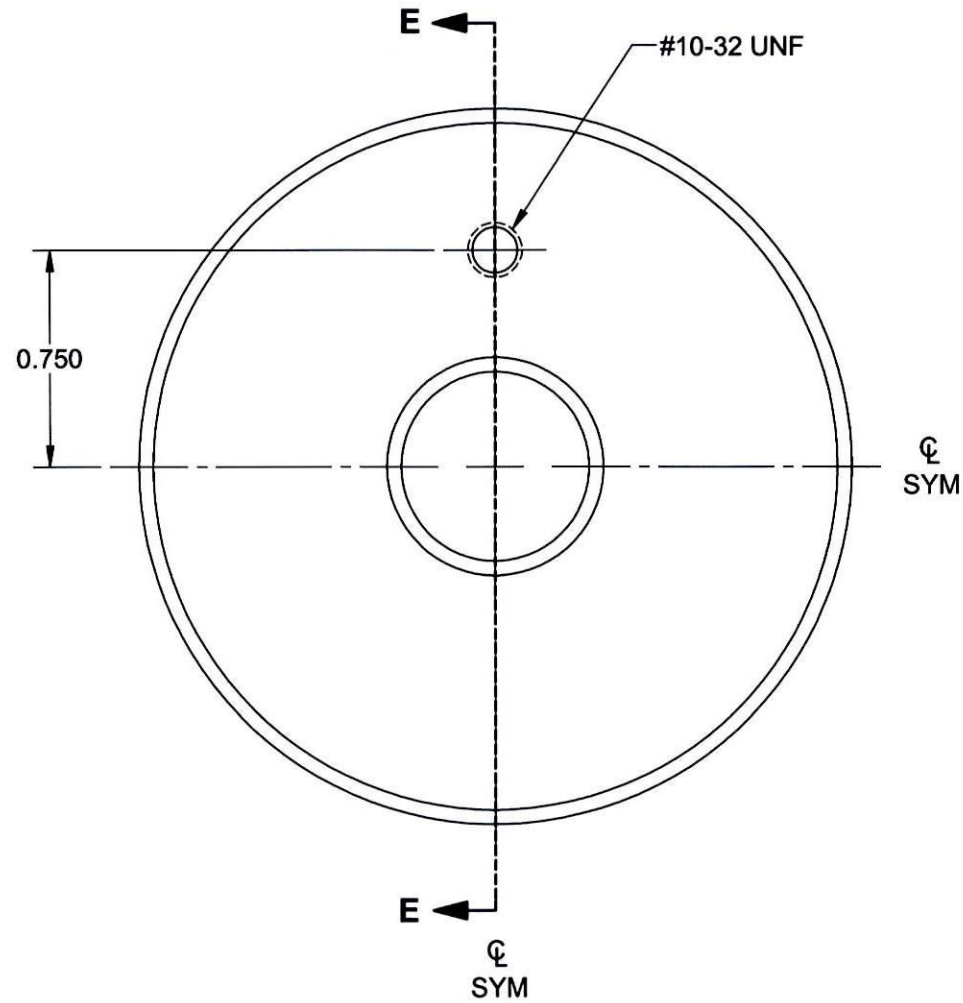
ITEM #	QTY	PART #	PART TITLE
-1	1	RBT18649-2-1	SUPPORT
-2	1	RBT18649-2-2	SPECIAL BOLT



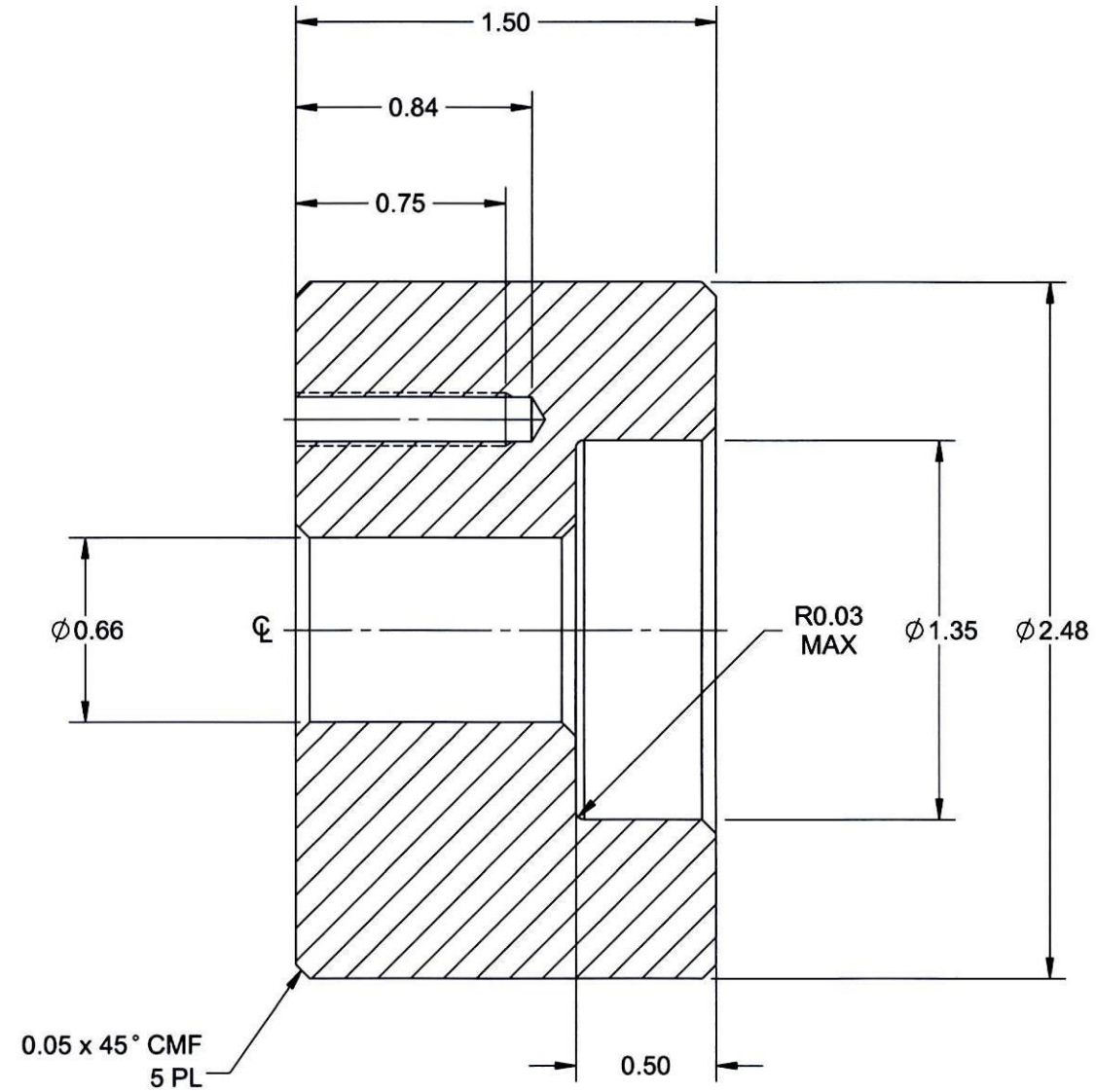
RBT18649-2 WORKAID ITEM #2

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) INSTALL HAND TIGHT

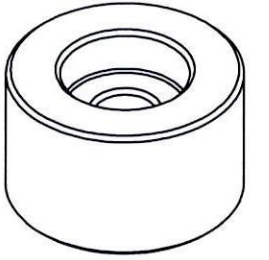
DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018	TOOL PART # RBT18649	REV. A
CHECKED	ML 04/18/2018		SHEET 6 OF 35
MFG. APPR.	DP 04/18/2018		
APPROVED	ML 04/19/2018	TITLE M/R HUB WORKAID KIT	SCALE NTS
DATE 4/19/2018		COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RBT18649-2-1 SUPPORT

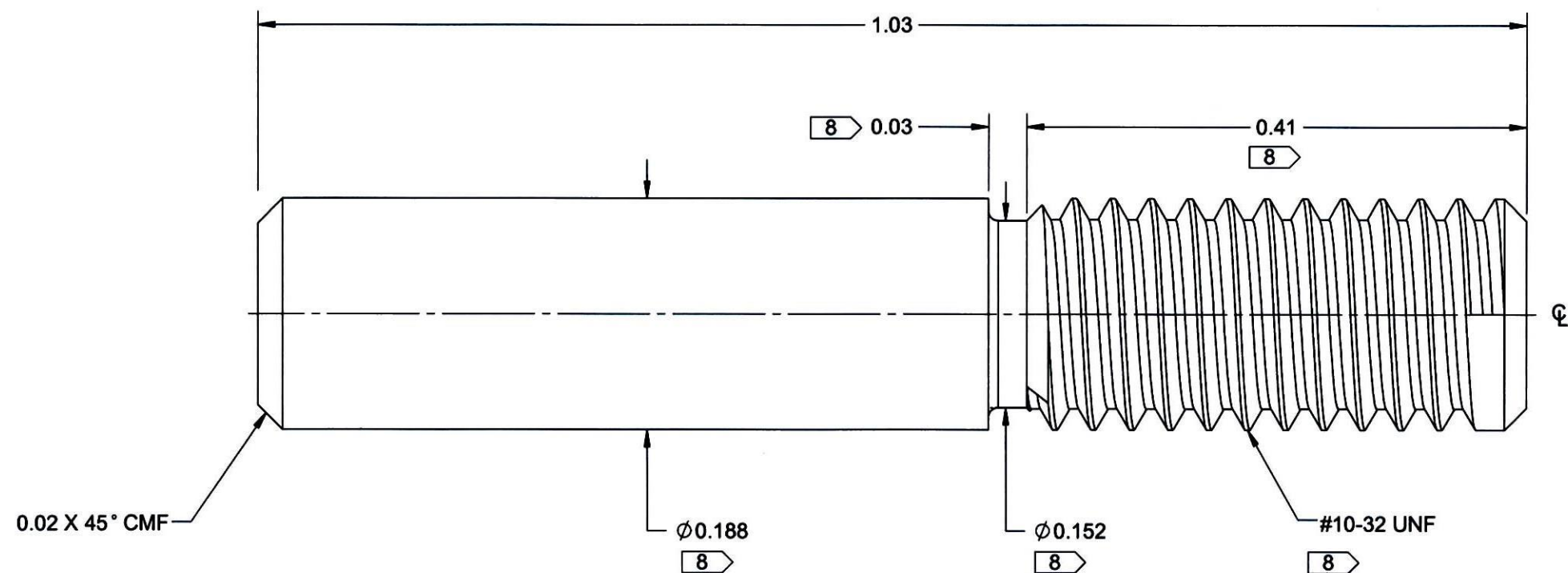


SECTION E-E



- NOTES:
- 1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 7 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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RBT18649-2-2 SPECIAL BOLT

NOTES:

1) MATERIAL: MAKE FROM AN3C10A BOLT OR 303/304/316 STAINLESS STEEL

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

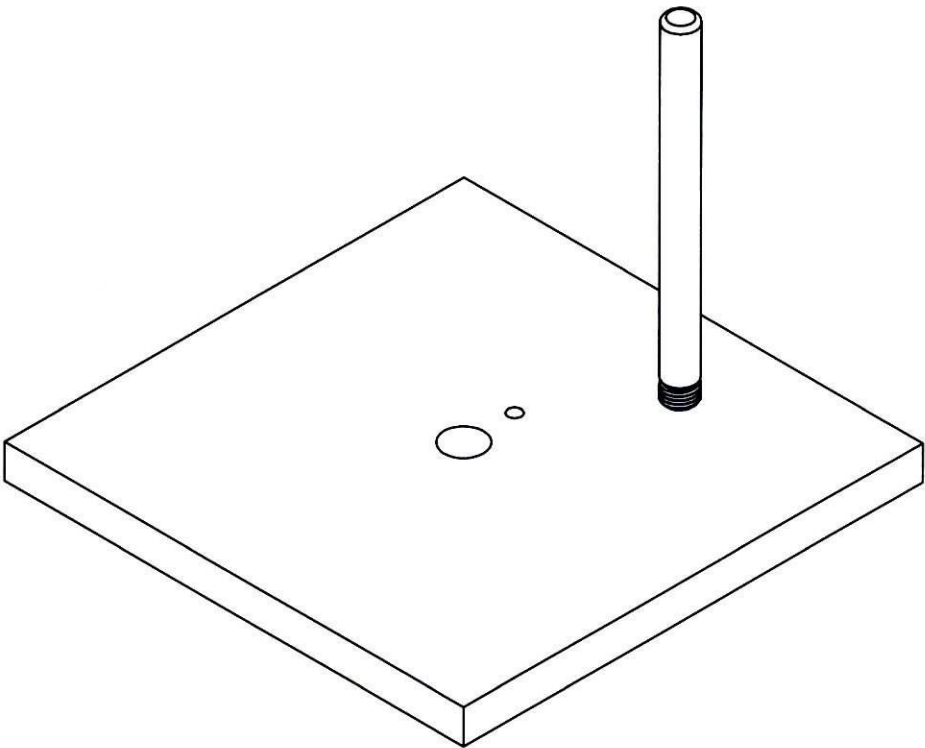
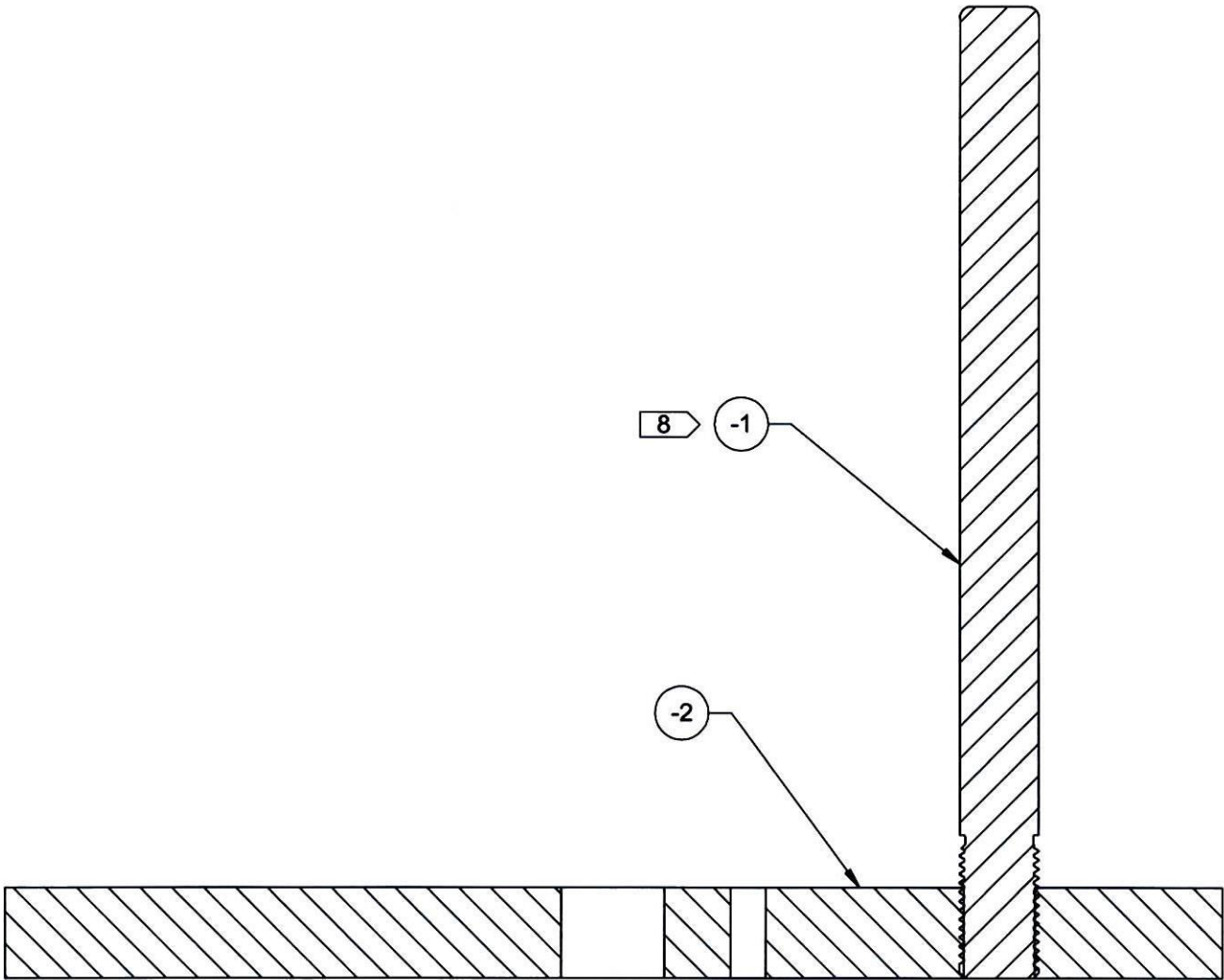
6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

8) DIMENSIONS ARE FOR REFERENCE ONLY IF THE PART IS MANUFACTURED FROM AN AN3C10A BOLT

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 8 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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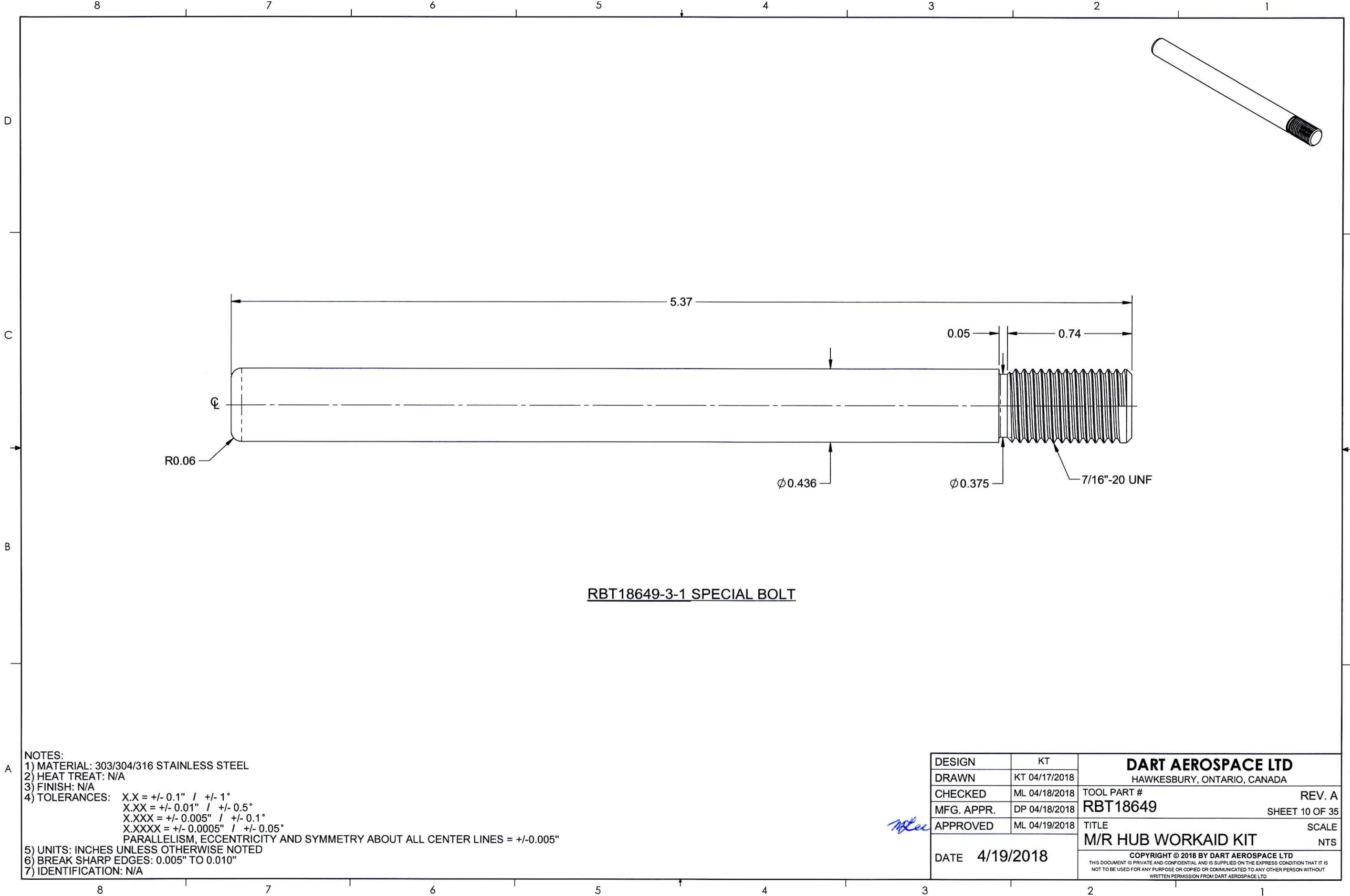
ITEM #	QTY	PART #	PART TITLE
-1	1	RBT18649-3-1	SPECIAL BOLT
-2	1	RBT18649-3-2	BASE



RBT18649-3 WORKAID ITEM #3

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) INSTALL HAND TIGHT

DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 9 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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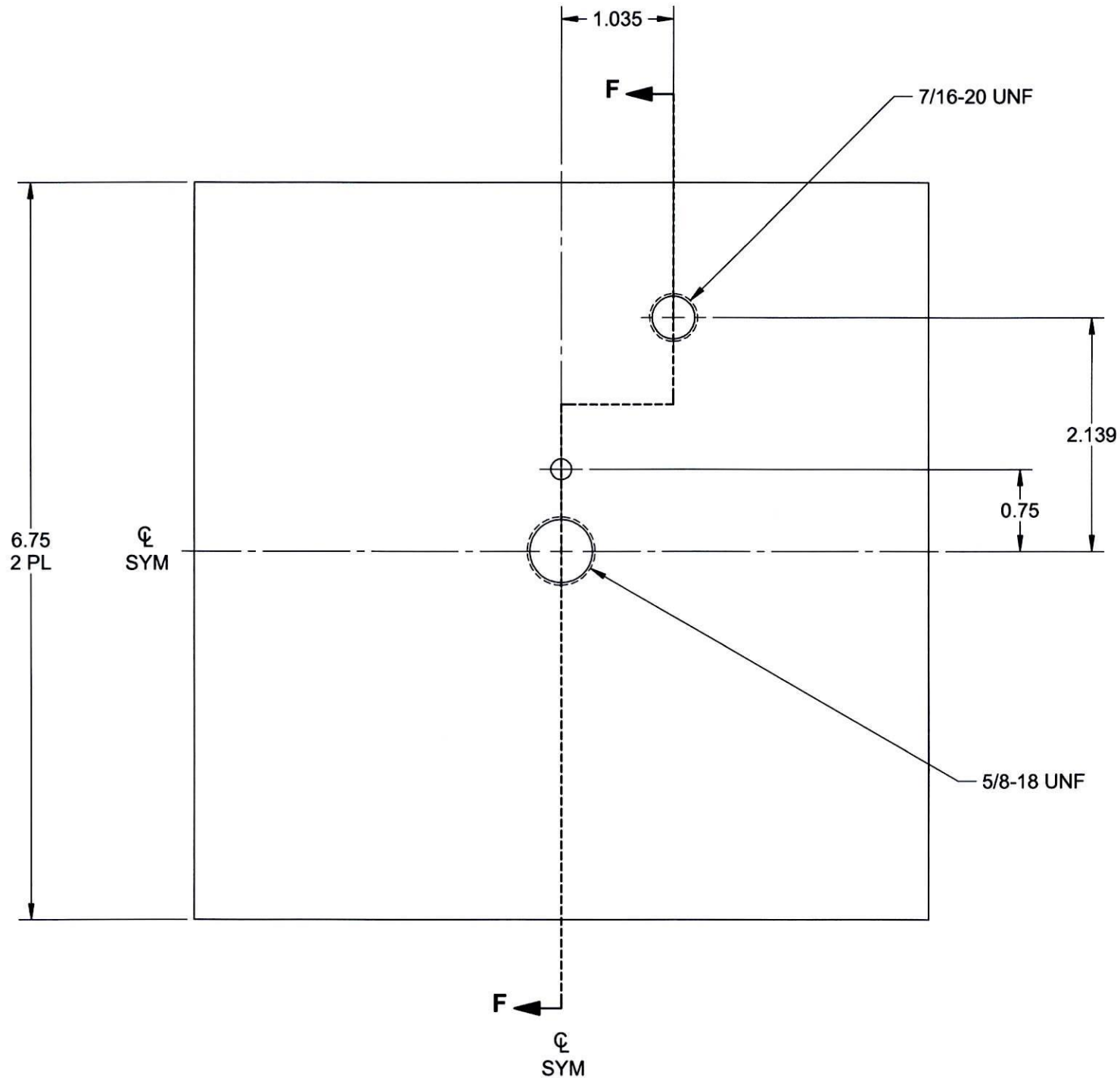


RBT18649-3-1 SPECIAL BOLT

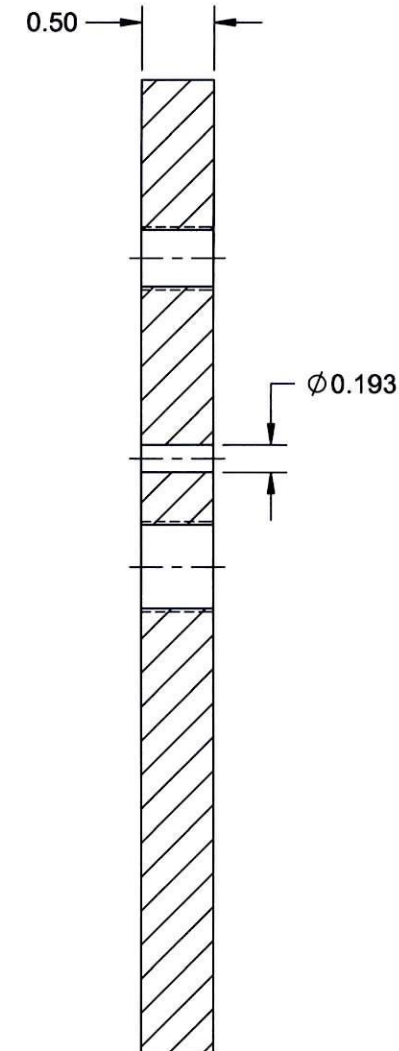
NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 10 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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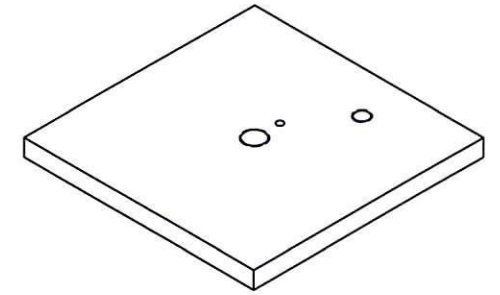
D
C
B
A



RBT18649-3-2 BASE



SECTION F-F



- NOTES:
- 1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

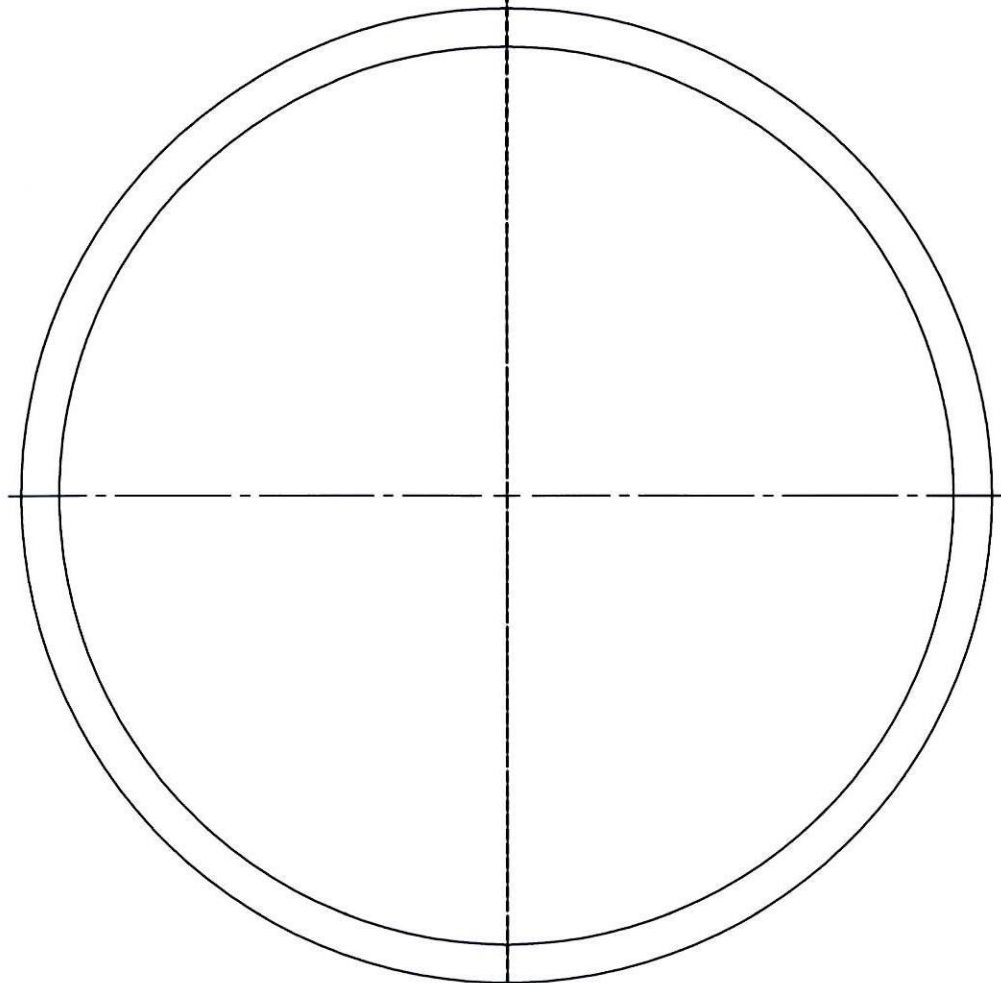
DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 11 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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D

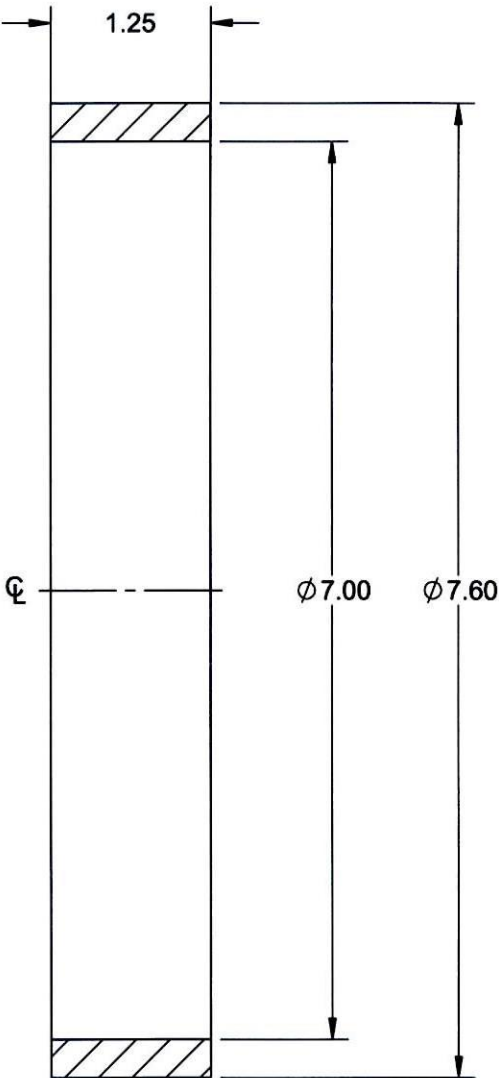
C

B

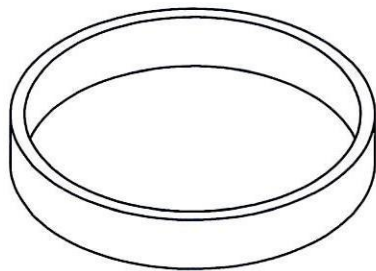
A



RBT18649-4 WORKAID ITEM #4



SECTION G-G



D

C

B

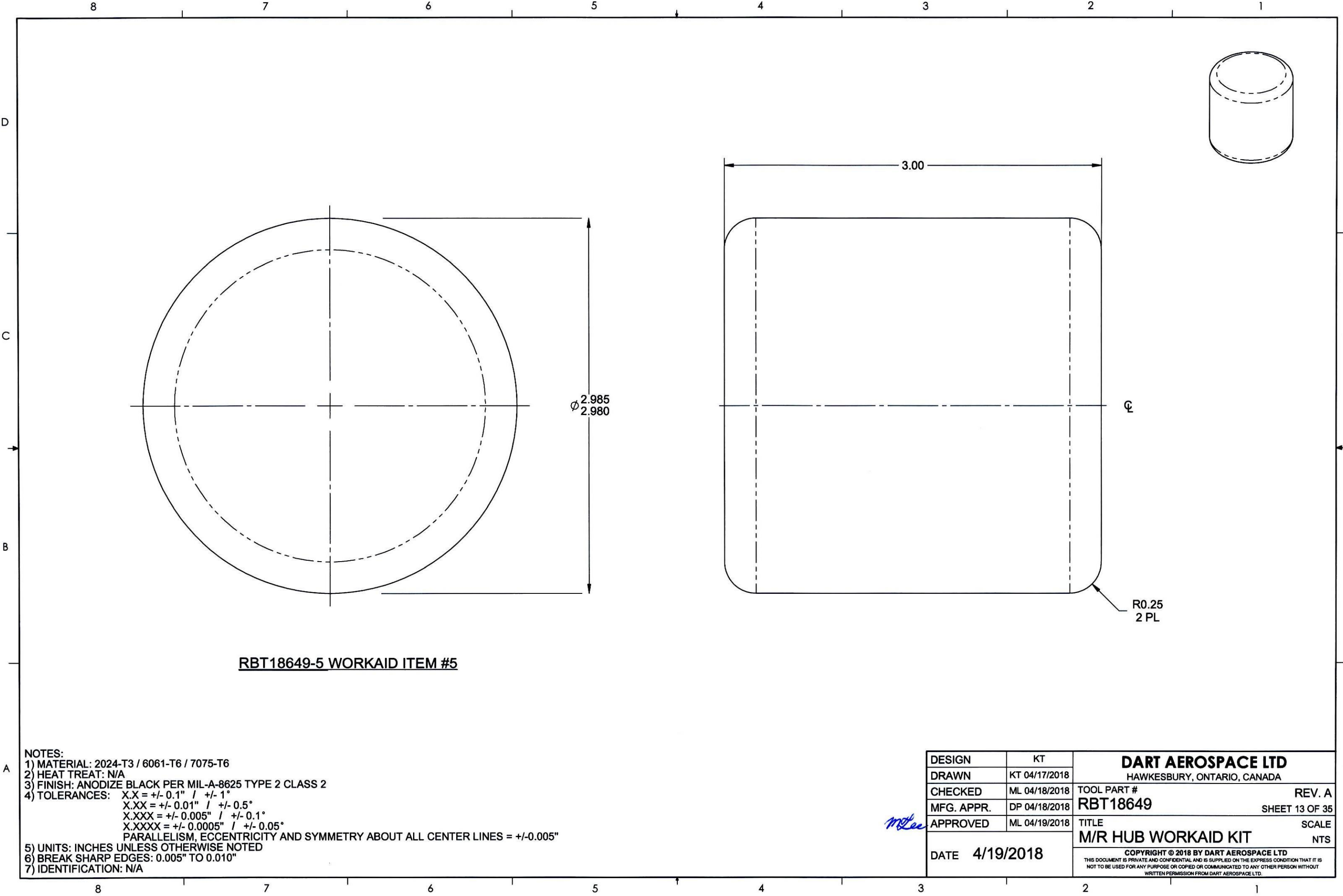
A

NOTES:

- 1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

M. Lee

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 12 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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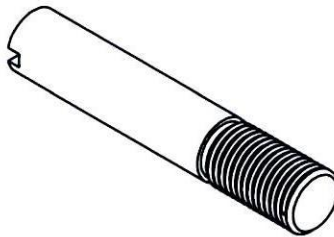
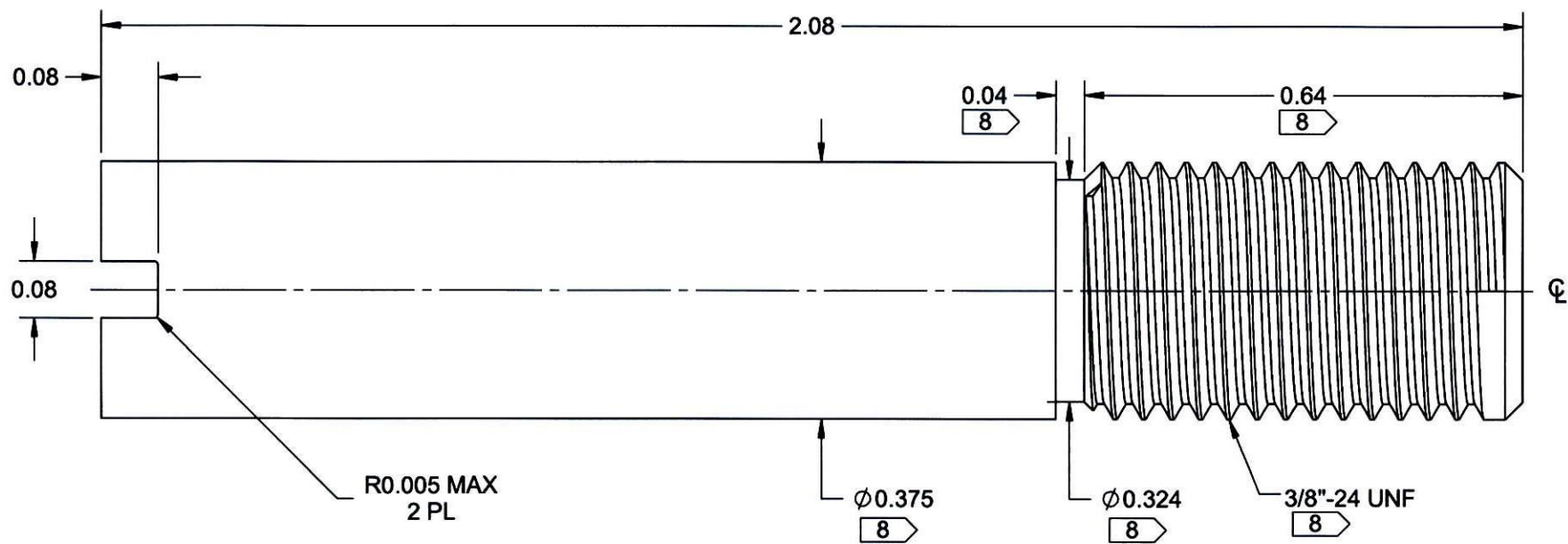
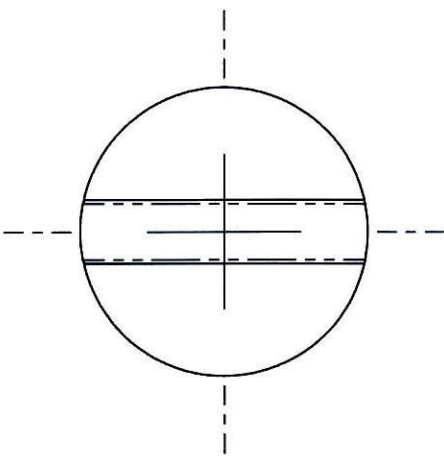
RBT18649-5 WORKAID ITEM #5

NOTES:
1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

ML

DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 13 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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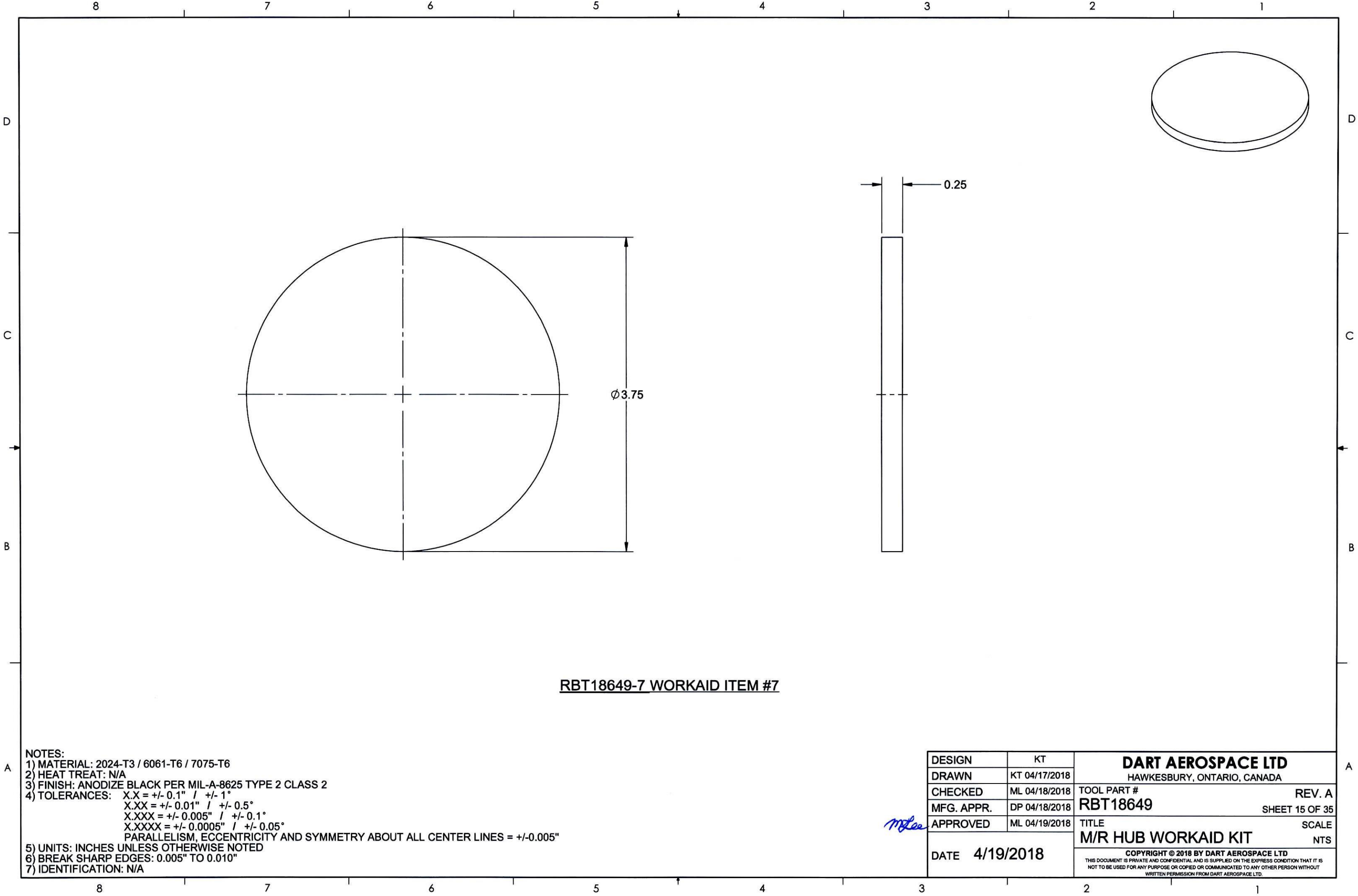
8 7 6 5 4 3 2 1



RBT18649-6 WORKAID ITEM #6

NOTES:
1) MATERIAL: MAKE FROM AN6C20A BOLT OR 303/304/316 STAINLESS STEEL
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A
8) DIMENSIONS ARE FOR REFERENCE ONLY IF THE PART IS MANUFACTURED FROM AN AN3C10A BOLT

DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 14 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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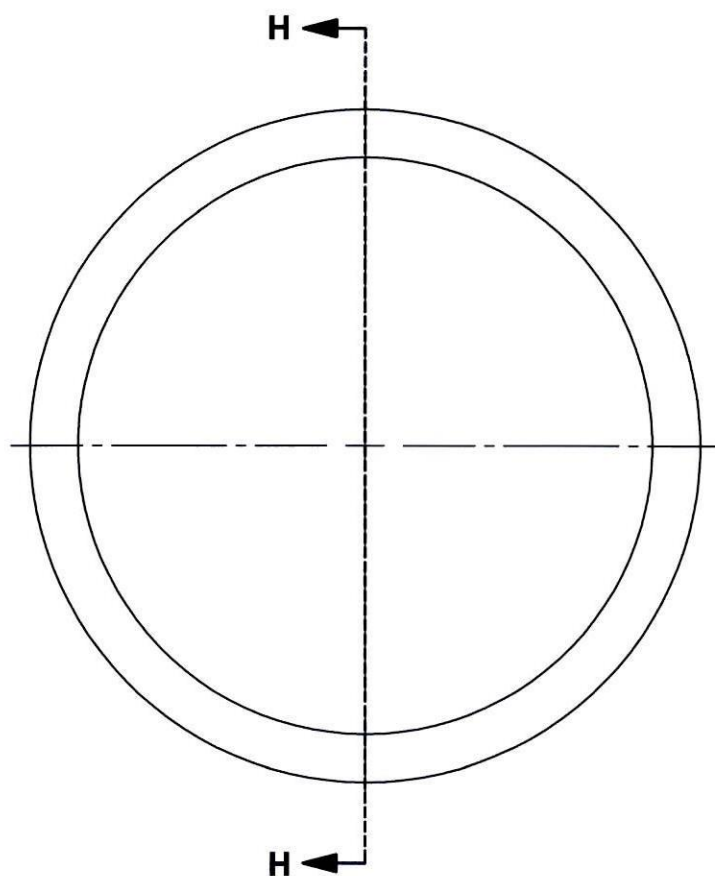


RBT18649-7 WORKAID ITEM #7

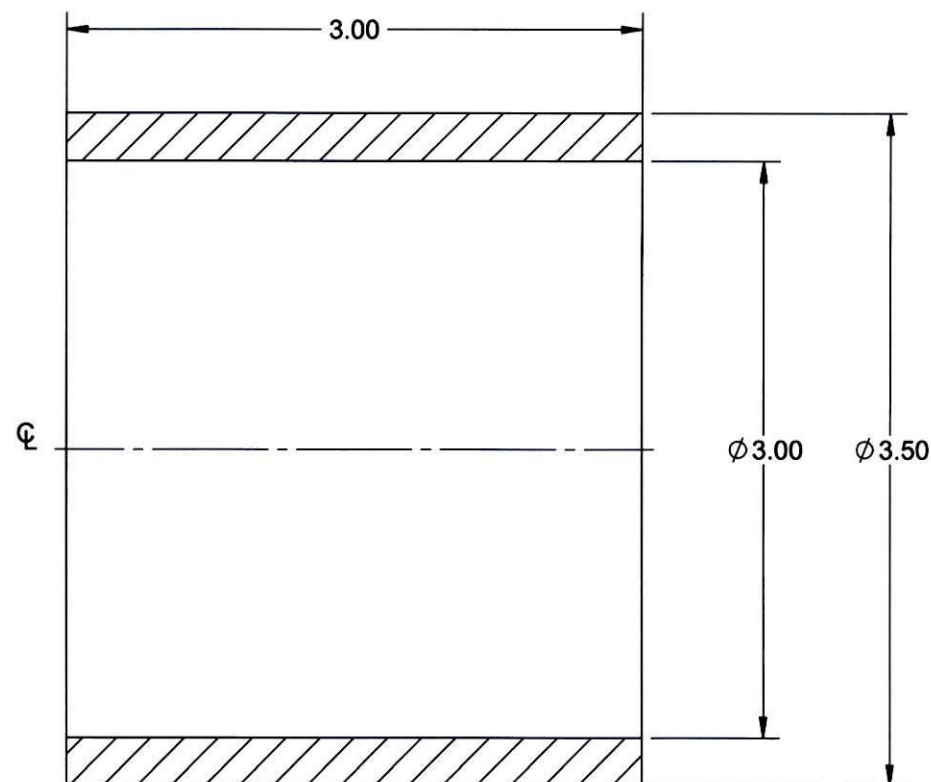
NOTES:
1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

ML

DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 15 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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RBT18649-8 WORKAID ITEM #8



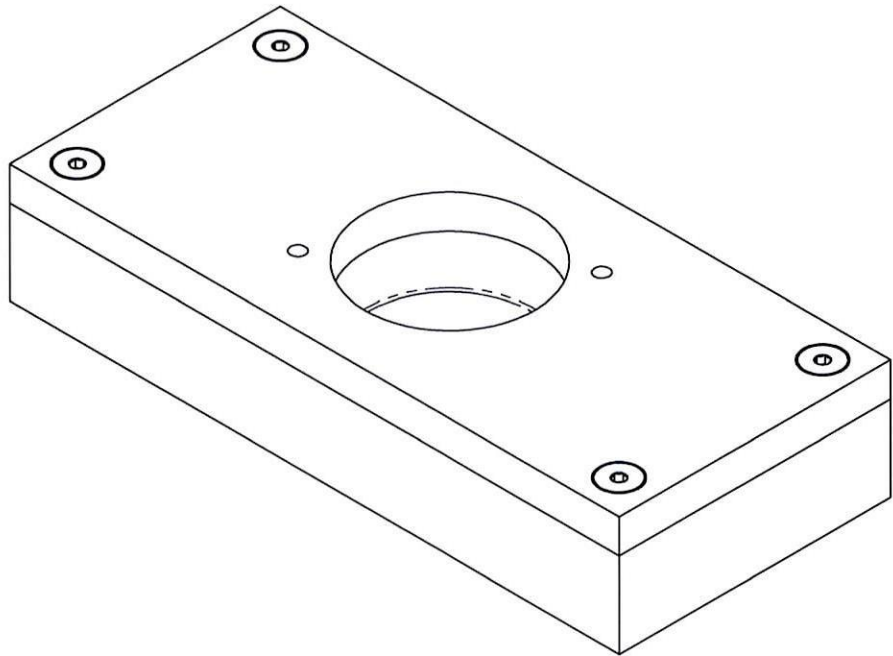
SECTION H-H

NOTES:

- NOTES:
- 1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: $XX = \pm 0.1" \quad / \quad \pm 1^\circ$
 $XX.X = \pm 0.01" \quad / \quad \pm 0.5^\circ$
 $XX.XXX = \pm 0.005" \quad / \quad \pm 0.1^\circ$
 $XX.XXXX = \pm 0.0005" \quad / \quad \pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

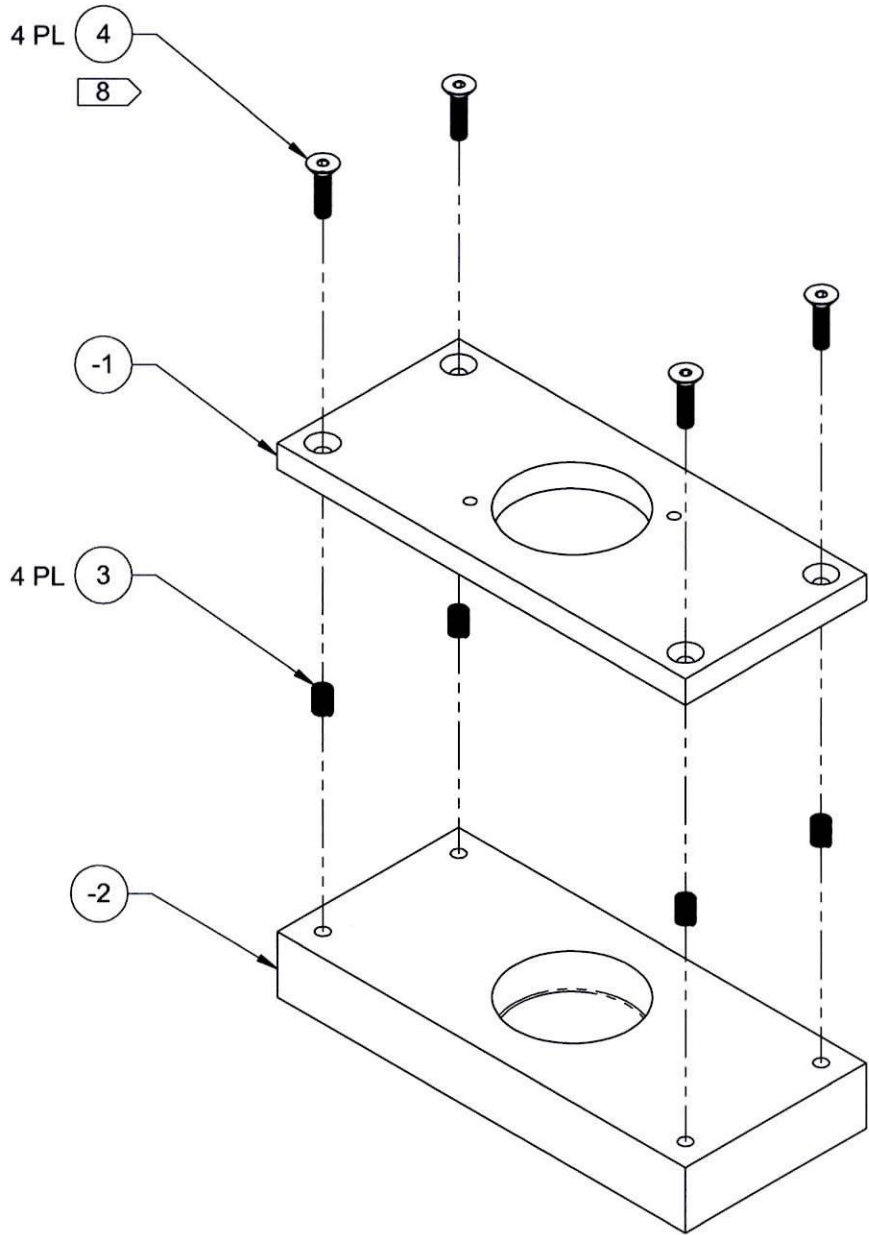
DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. 1
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 16 OF 3
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NT
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ITEM #	QTY	PART #	PART TITLE
-1	1	RBT18649-9-1	TOP PLATE
-2	1	RBT18649-9-2	BOTTOM BASE
3	4	McMaster#91732A737	1/4"-28 X 0.5" LG. SS HELICAL INSERT
4	4	McMaster#92210A336	1/4"-28 X 1" LG SS FLAT HEAD SCREW

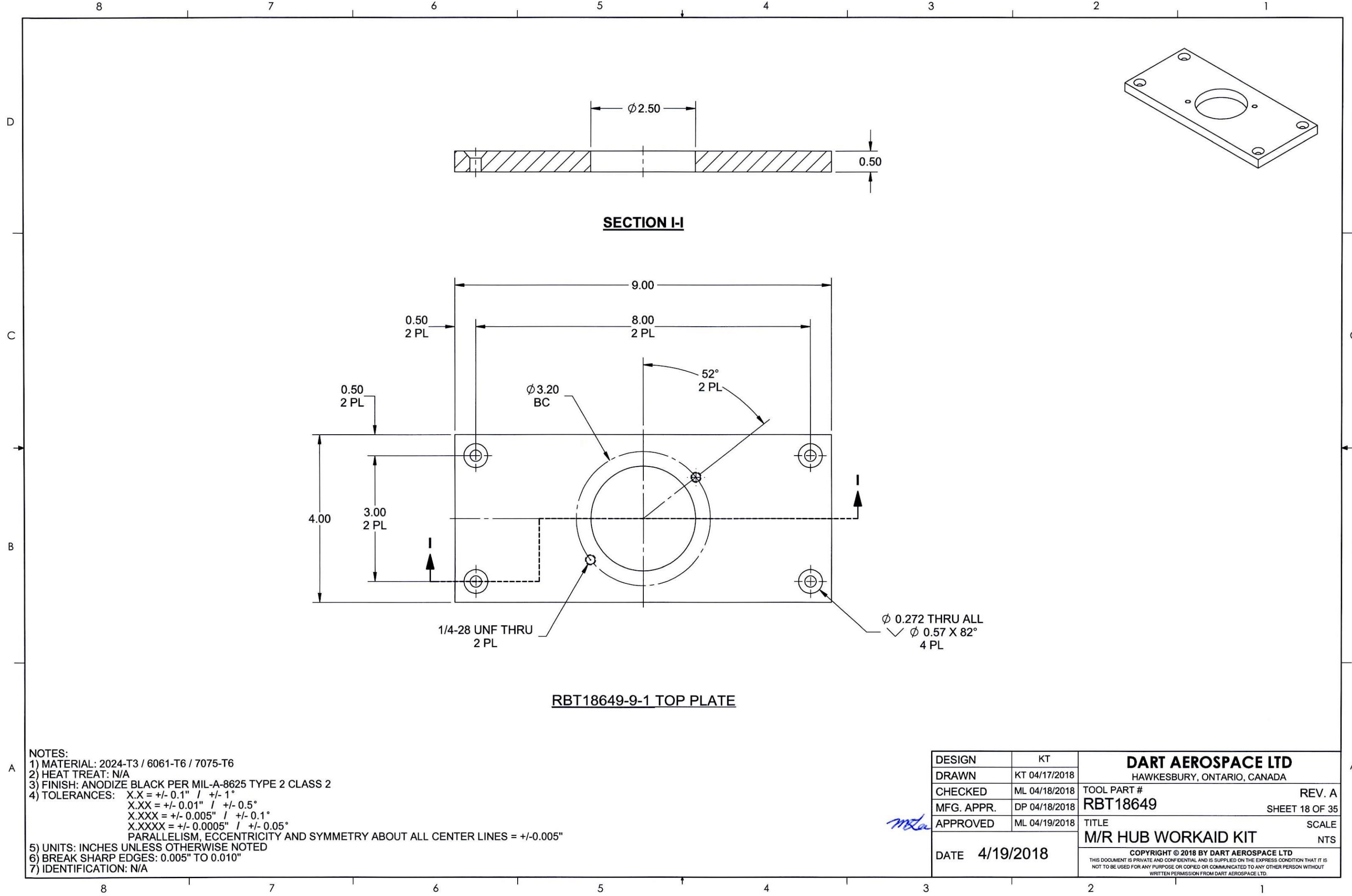


RBT18649-9 WORKAID ITEM #9

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) TORQUE FASTENERS 50 - 70 IN-LBS

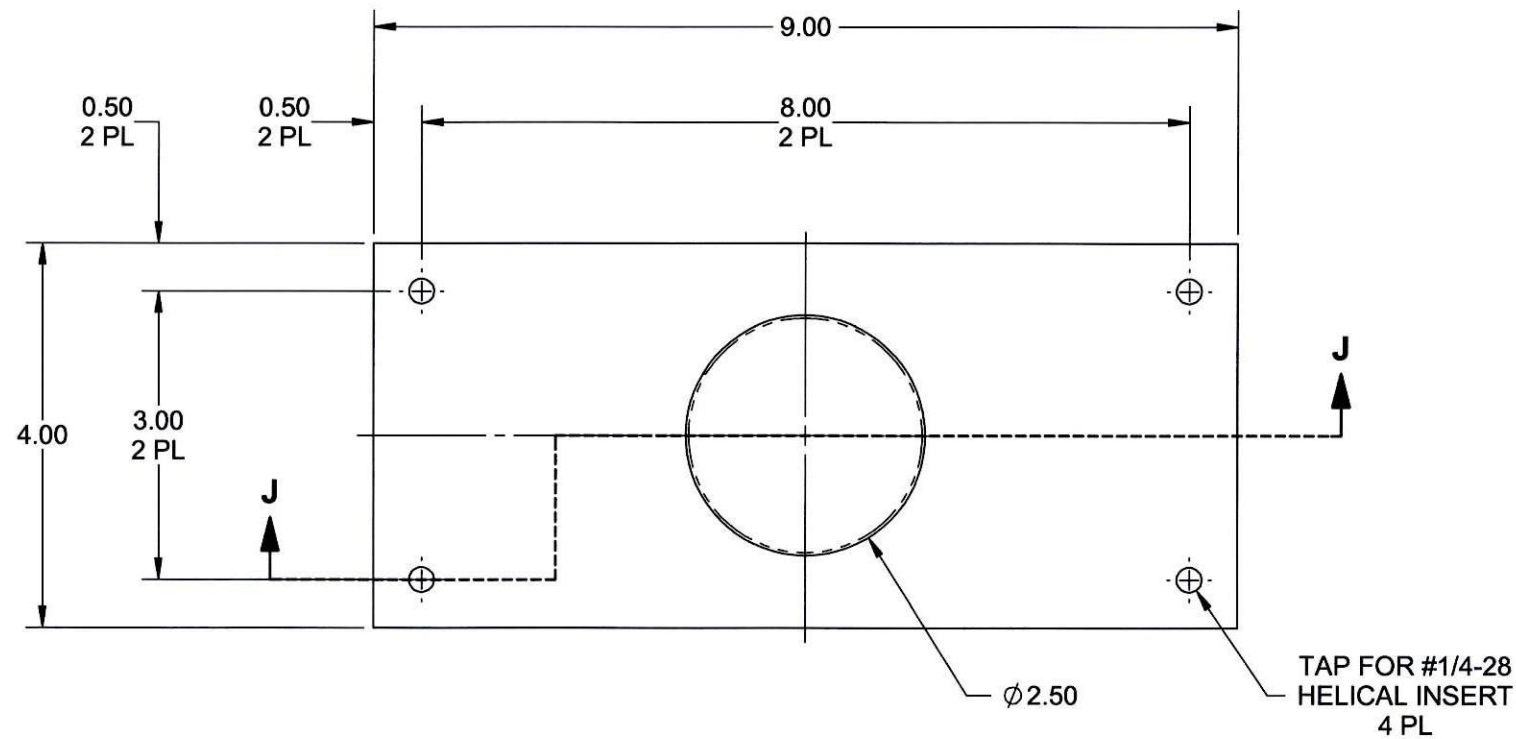


DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 17 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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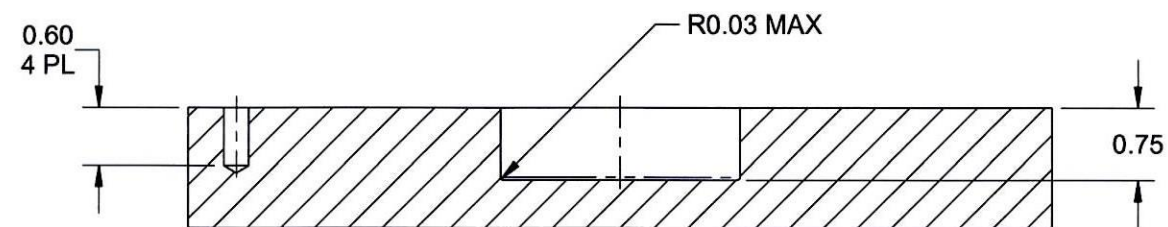


NOTES:
1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 18 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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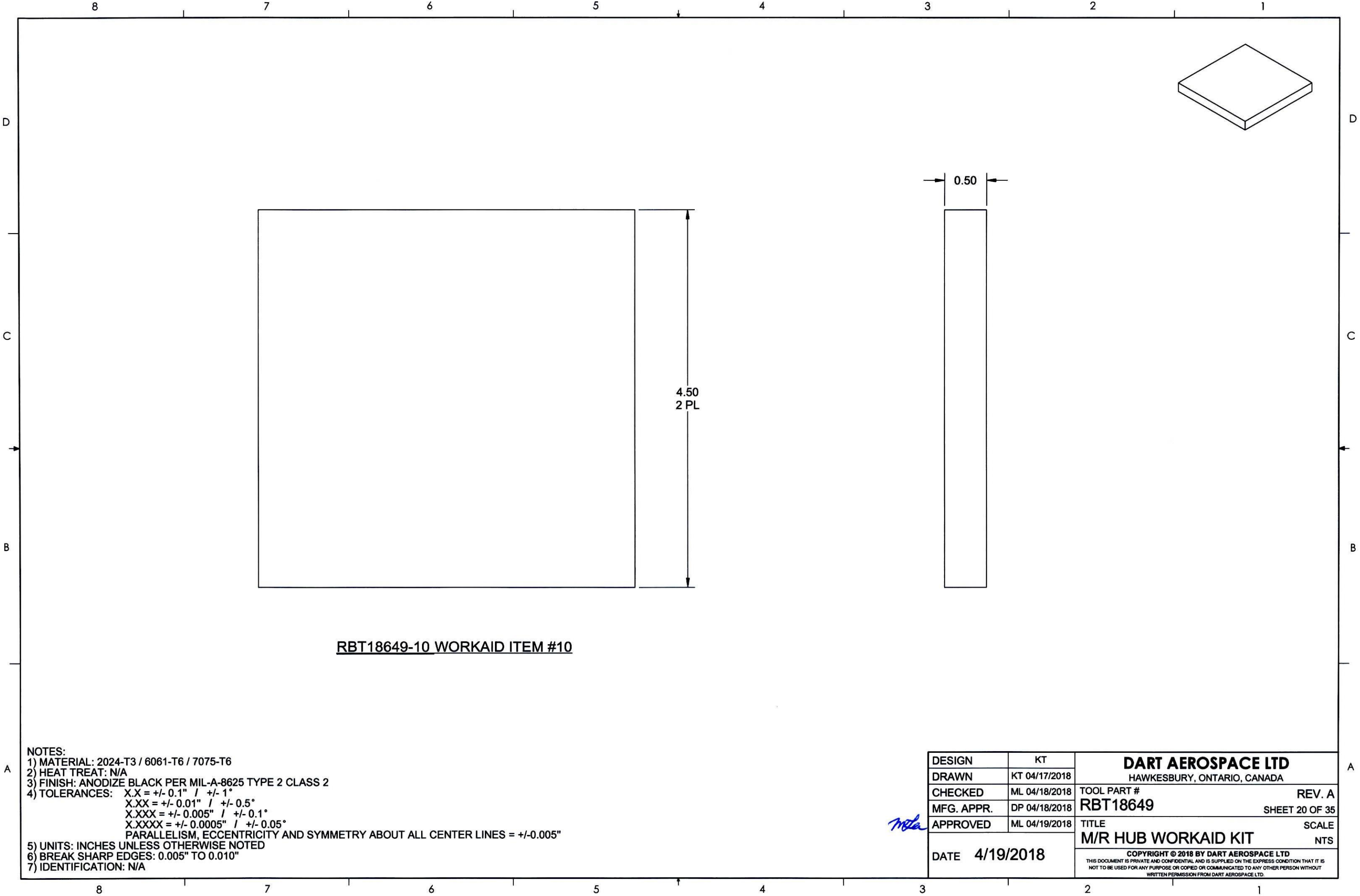
RBT18649-9-2 BOTTOM BASE

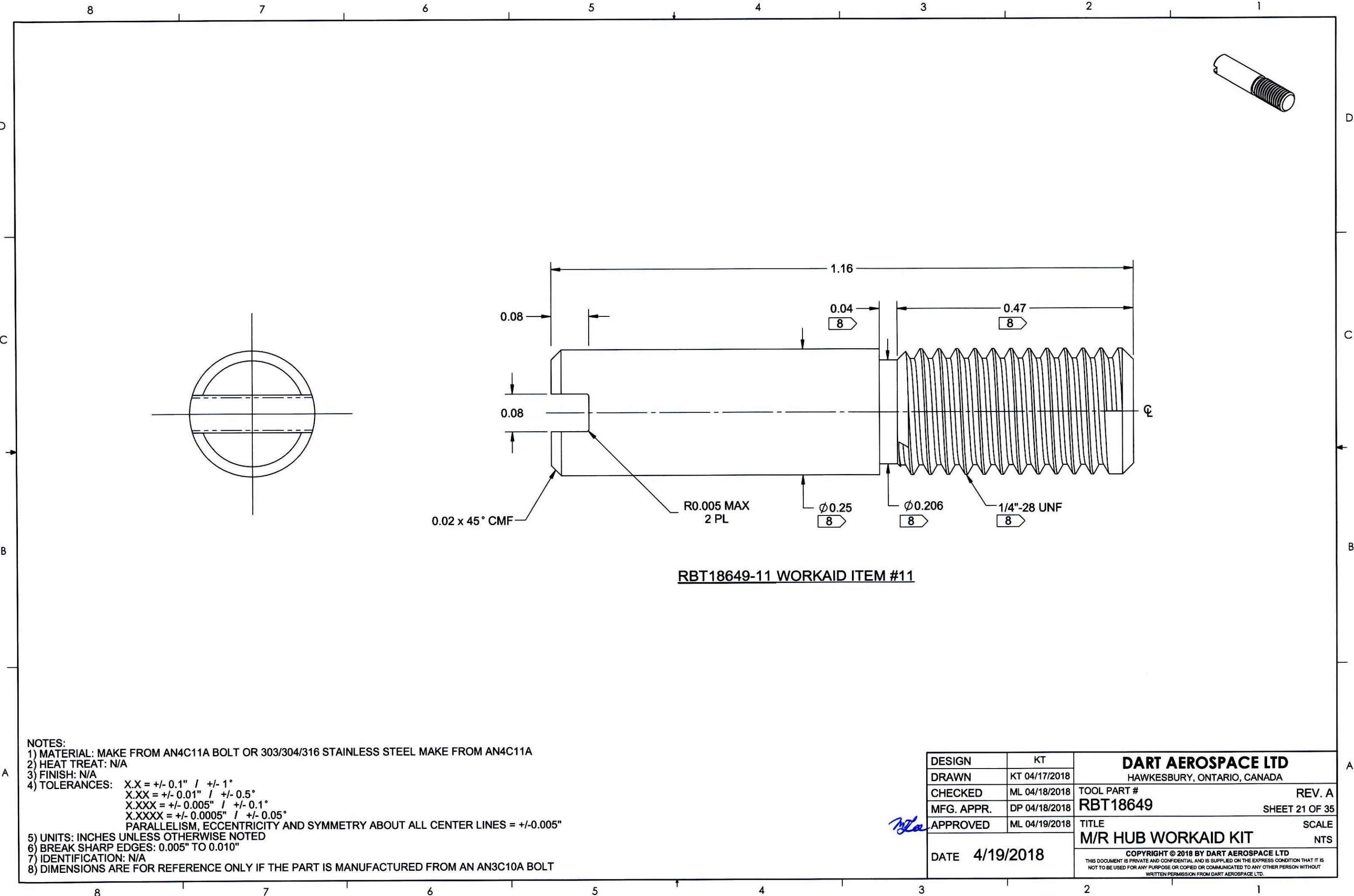


SECTION J-J

NOTES:
1) MATERIAL: UHMW (BLACK)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 19 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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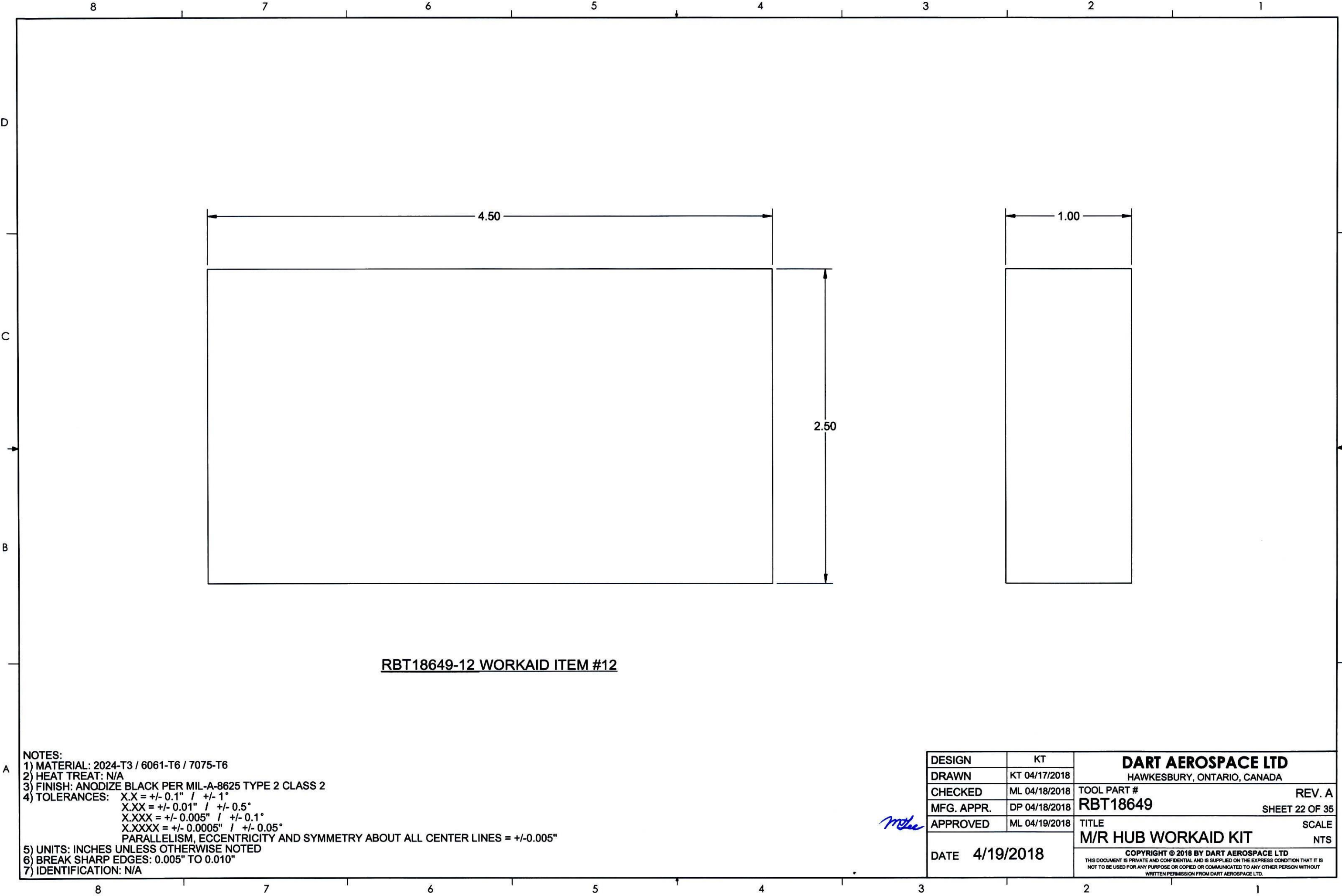




RBT18649-11 WORKAID ITEM #11

NOTES:
1) MATERIAL: MAKE FROM AN4C11A BOLT OR 303/304/316 STAINLESS STEEL MAKE FROM AN4C11A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A
8) DIMENSIONS ARE FOR REFERENCE ONLY IF THE PART IS MANUFACTURED FROM AN AN3C10A BOLT

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 21 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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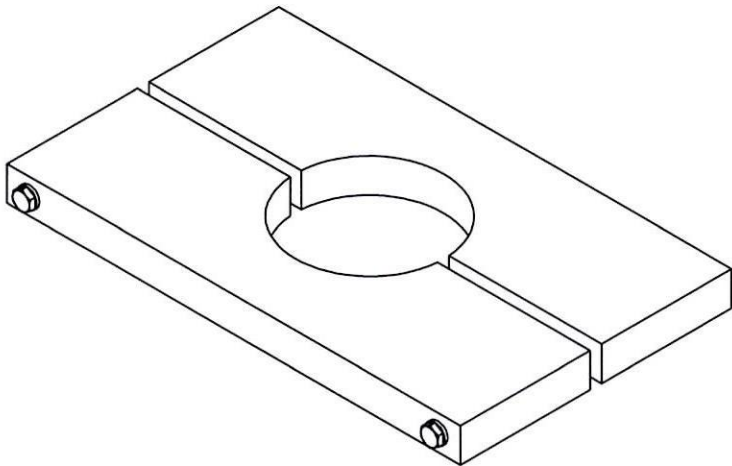
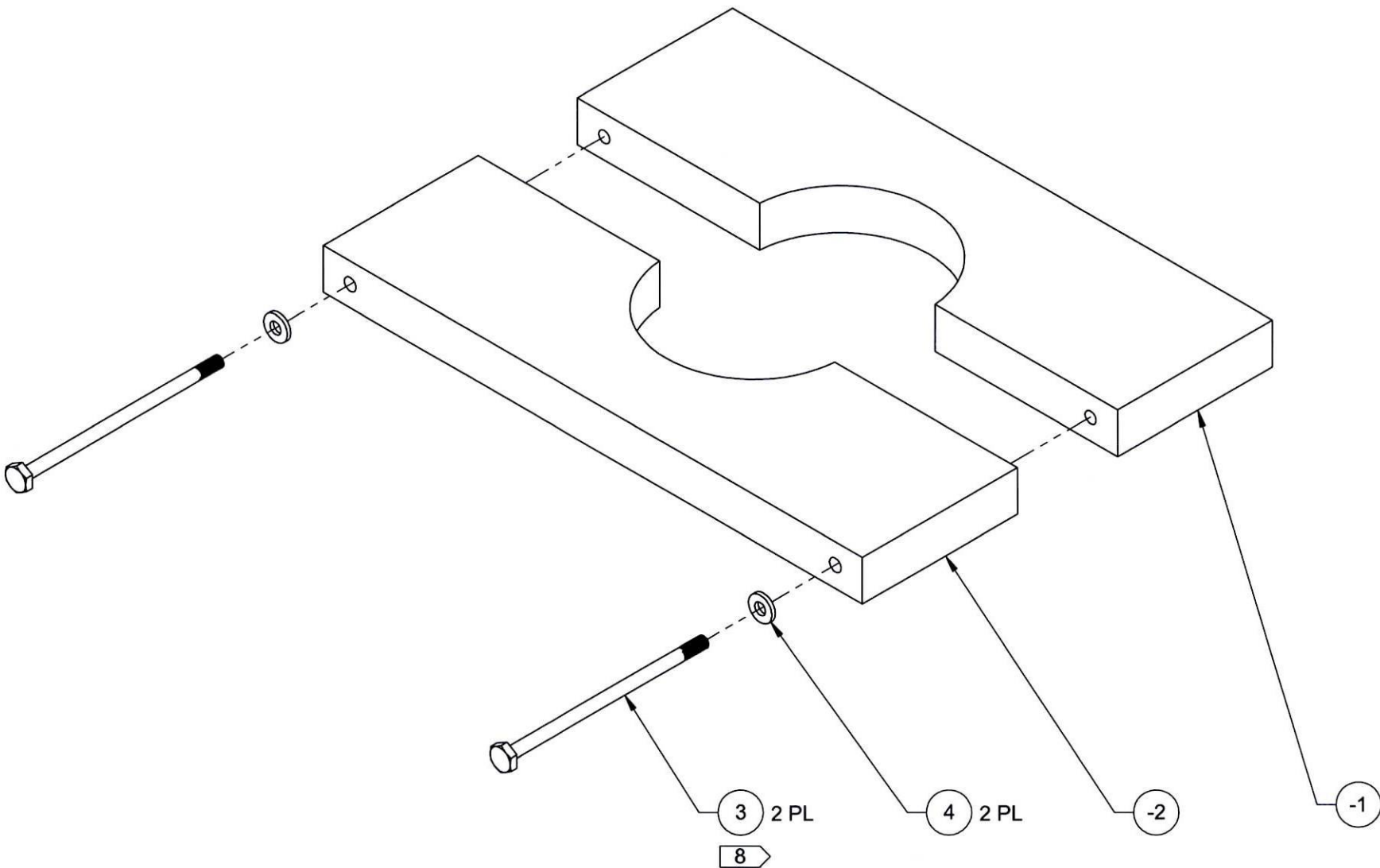


NOTES:
1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

ML

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 22 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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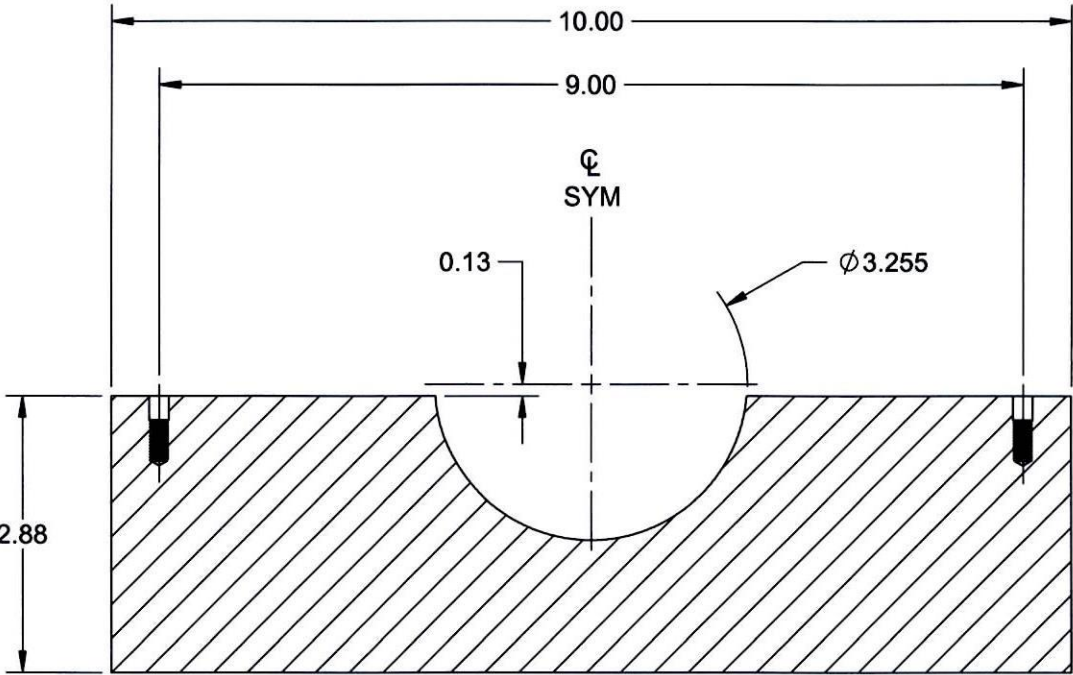
ITEM #	QTY	PART #	PART TITLE
-1	1	RBT18649-13-1	TOP BASE
-2	1	RBT18649-13-2	BOTTOM BASE
3	2	AN3C35A	#10-32 X 3-21/32" LG. SS HEX HEAD BOLT
4	2	NAS1149C0363R	0.438 OD. X 0.203 ID X 0.063 THK. SS FLAT WASHER



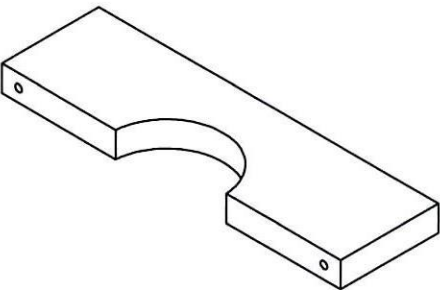
NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A
8) INSTALL HAND TIGHT

RBT18649-13 WORKAID ITEM #13

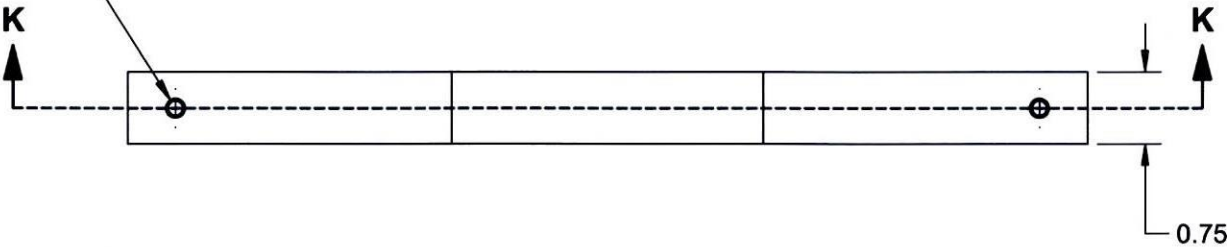
DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 23 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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SECTION K-K



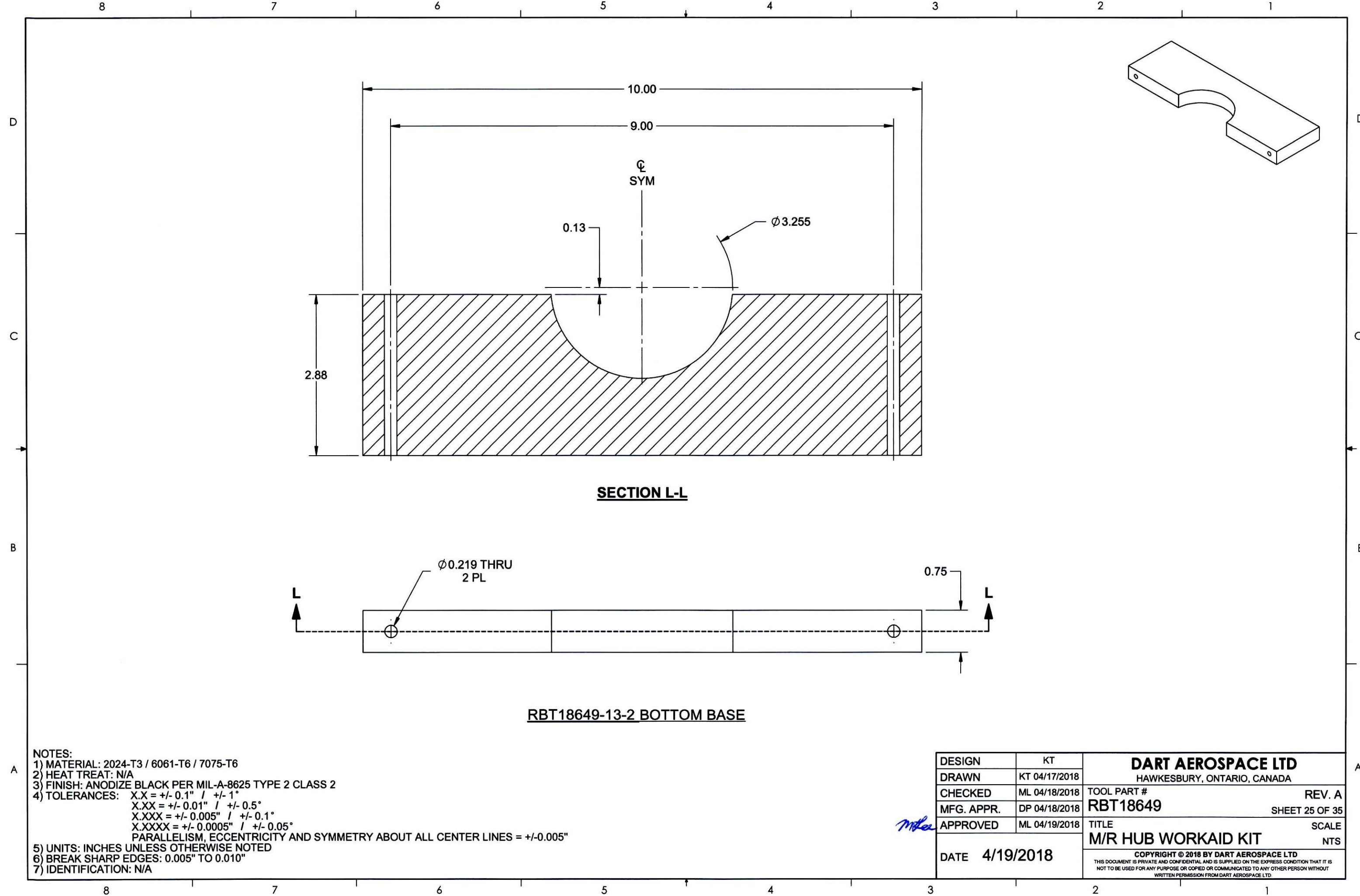
TAP #10-32 $\nabla 0.71$
 $\square \phi 0.203 \nabla 0.25$
2 PL



RBT18649-13-1 TOP BASE

NOTES:
1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 24 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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NOTES:
1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 25 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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D

C

B

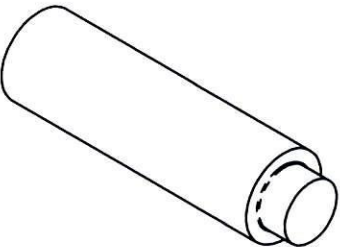
A

D

C

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A



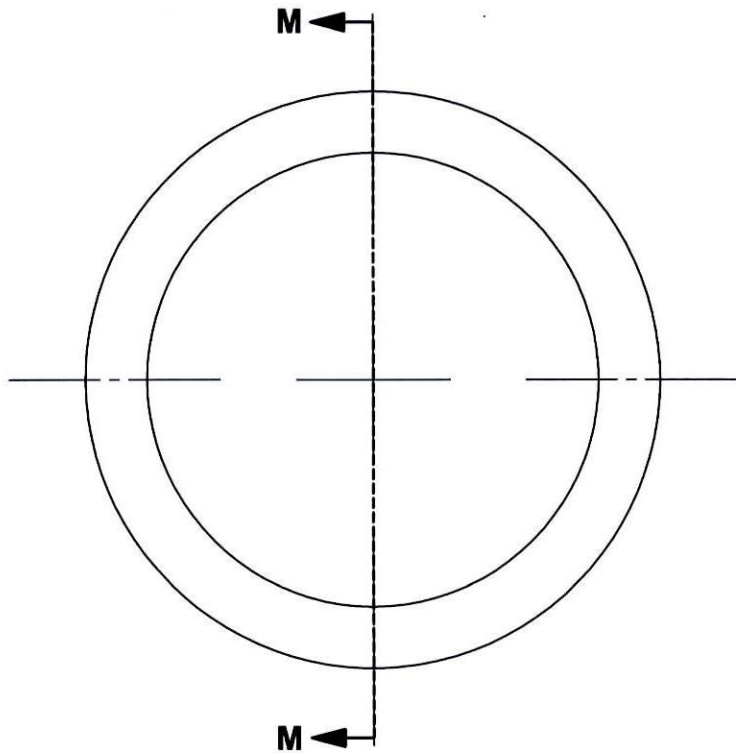
RBT18649-14 WORKAID ITEM #14

NOTES:
1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A
8) CENTER DRILL IS ACCEPTABLE

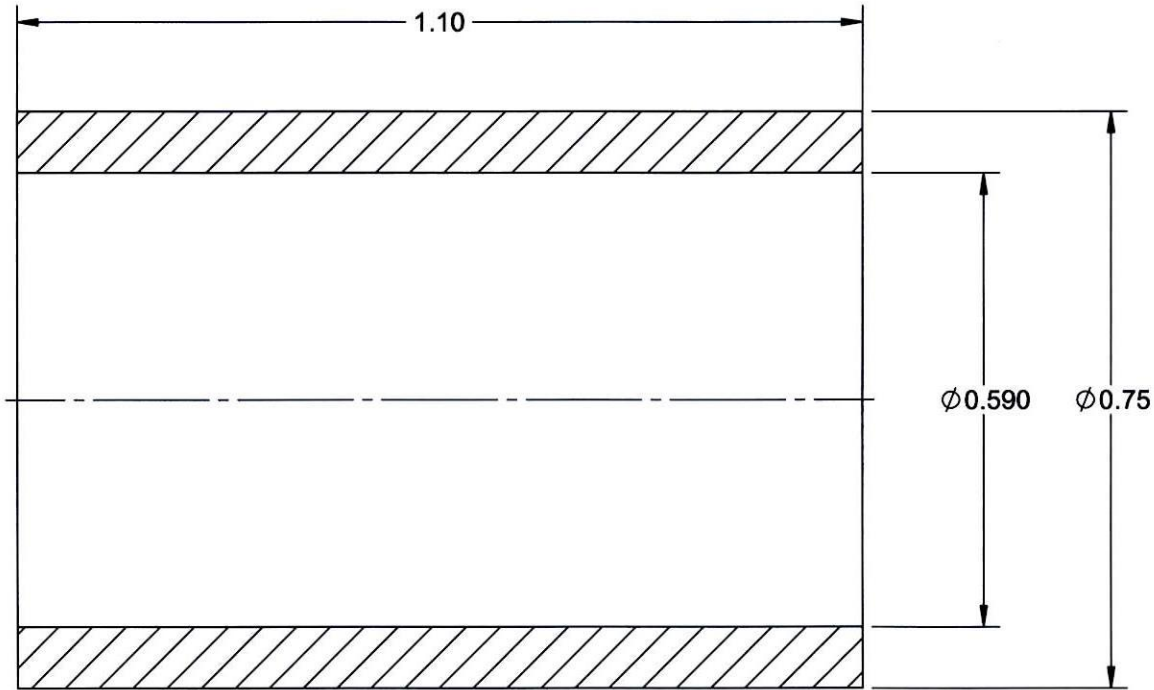
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DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 26 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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RBT18649-15 WORKAID ITEM #15



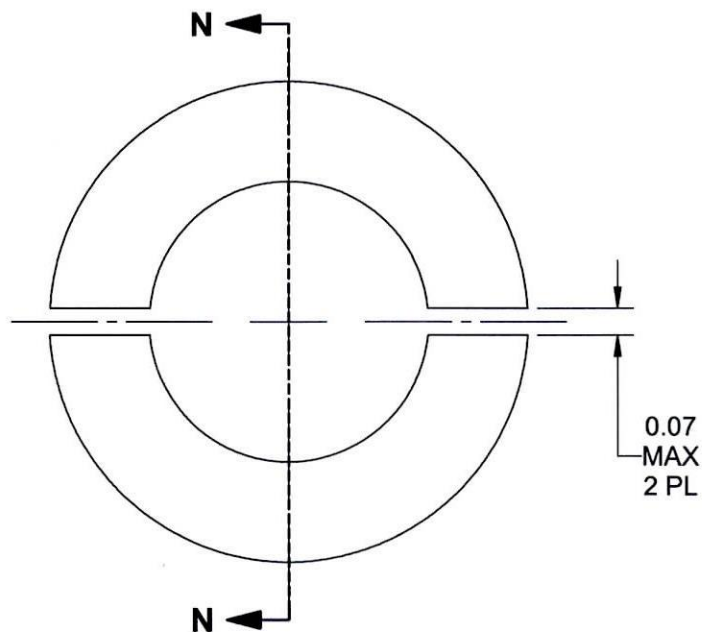
SECTION M-M

- NOTES:
- 1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

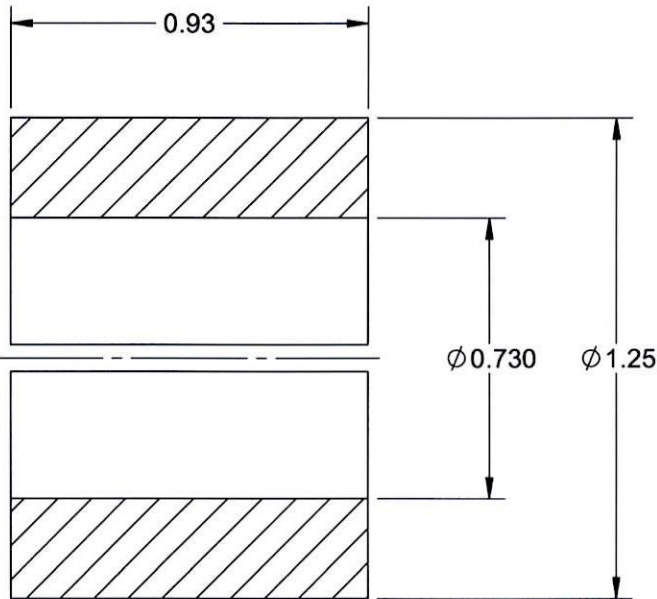
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DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 27 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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B
A



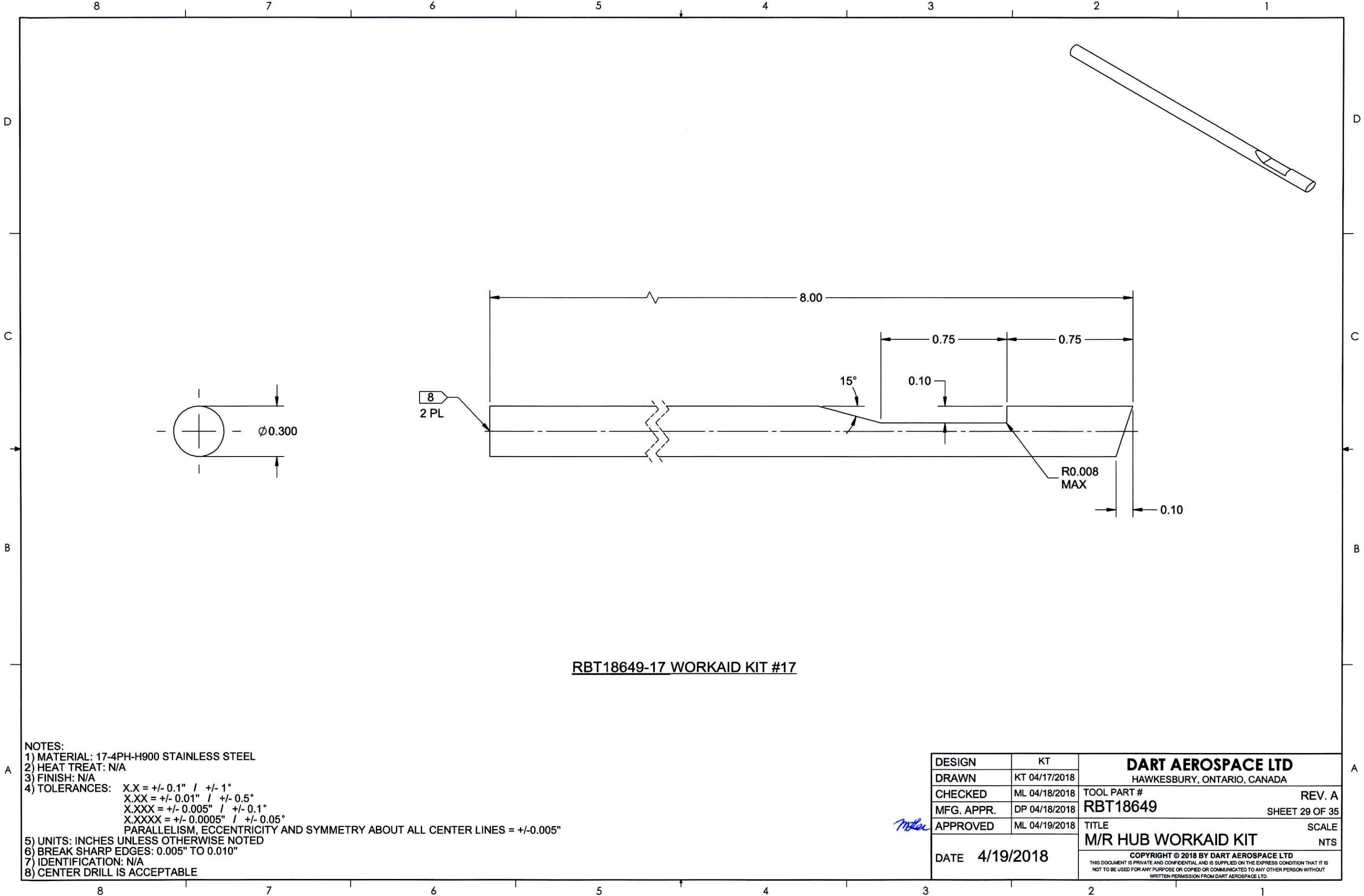
RBT18649-16 WORKAID ITEM #16

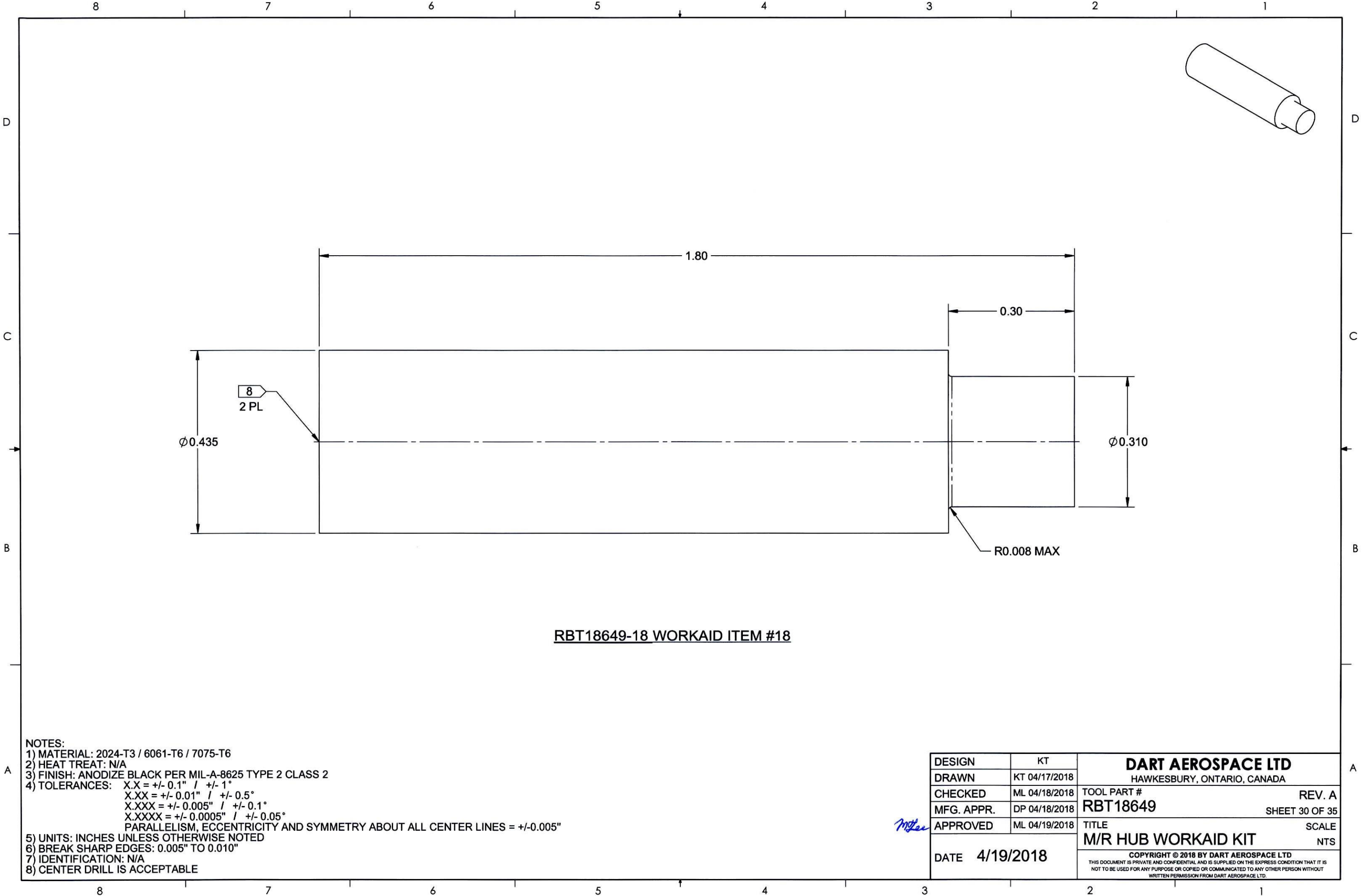


SECTION N-N

NOTES:
1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 28 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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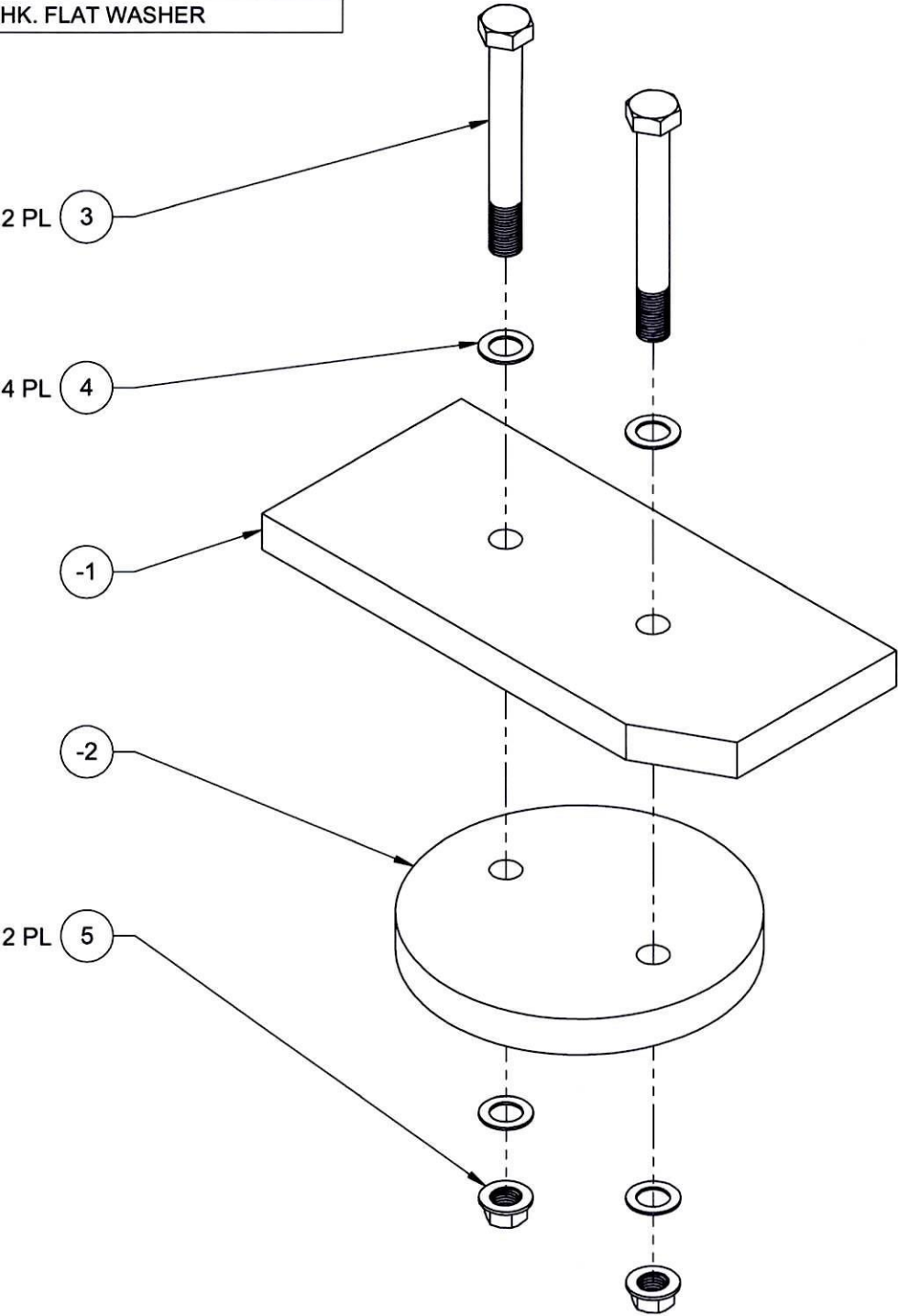
RBT18649-18 WORKAID ITEM #18

NOTES:
1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A
8) CENTER DRILL IS ACCEPTABLE

ML

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 30 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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ITEM #	QTY	PART #	PART TITLE
-1	1	RBT18649-19-1	BASE
-2	1	RBT18649-19-2	PLATE
3	2	AN6-27A	3/8"-24 X 2-61/64" LG. HEX HEAD BOLT
5	2	AN315-6R	3/8"-24 NUT
4	4	NAS1149F0632P	0.390 OD X 0.625 ID X 0.063 THK. FLAT WASHER



NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

RBT18649-19 WORKAID ITEM #19

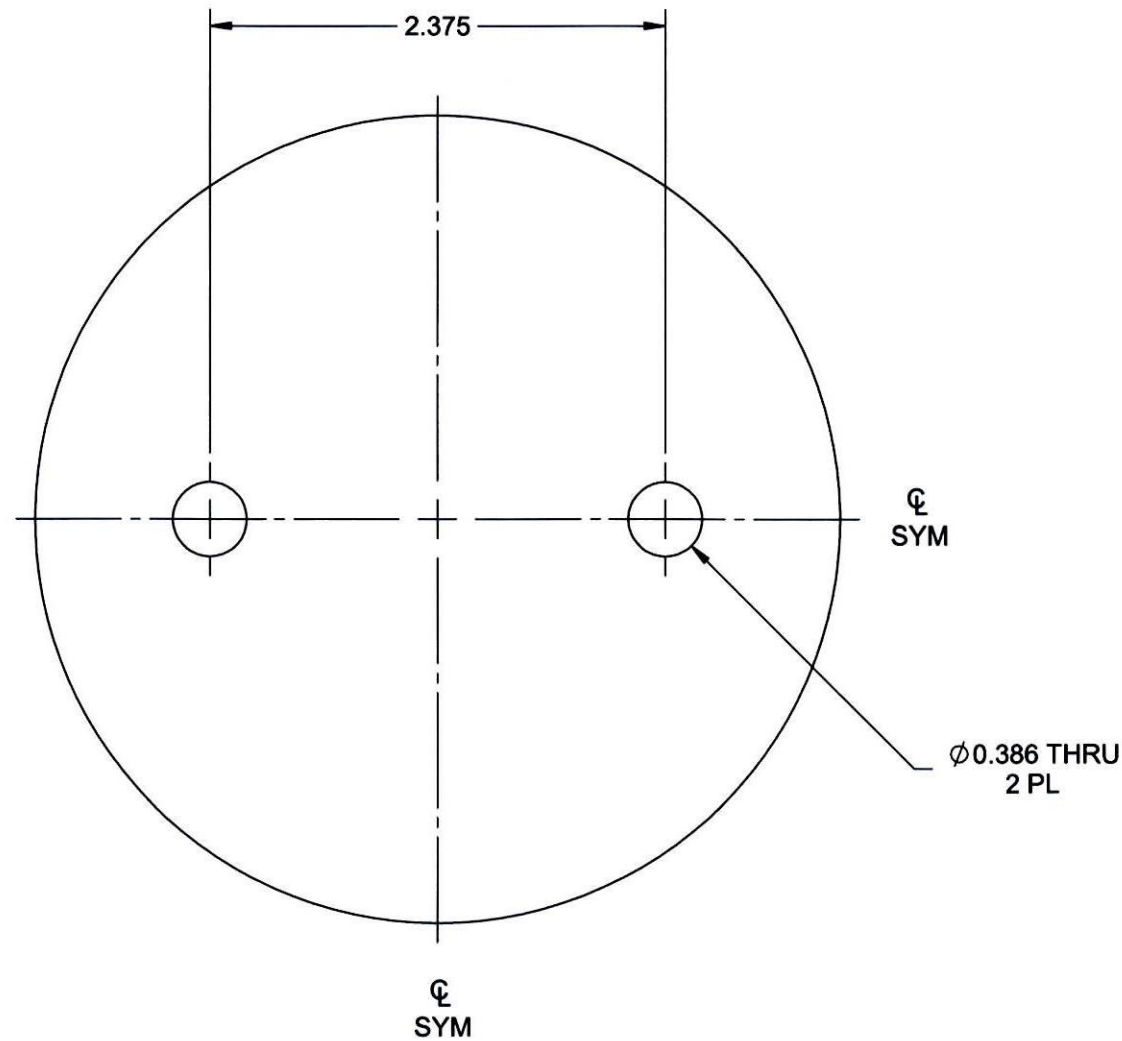
DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RB18649	SHEET 31 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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D

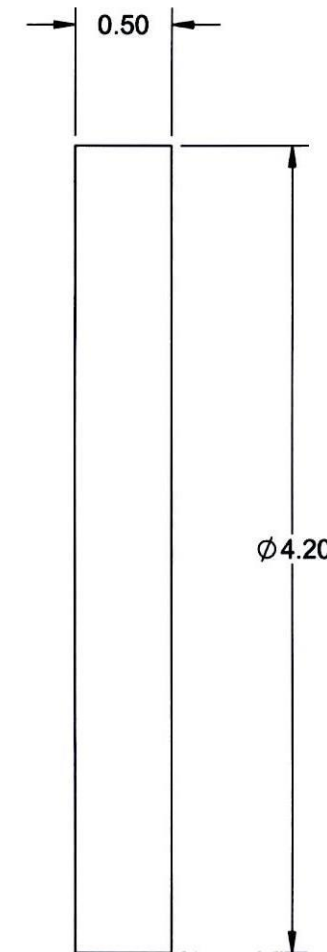
C

B

A

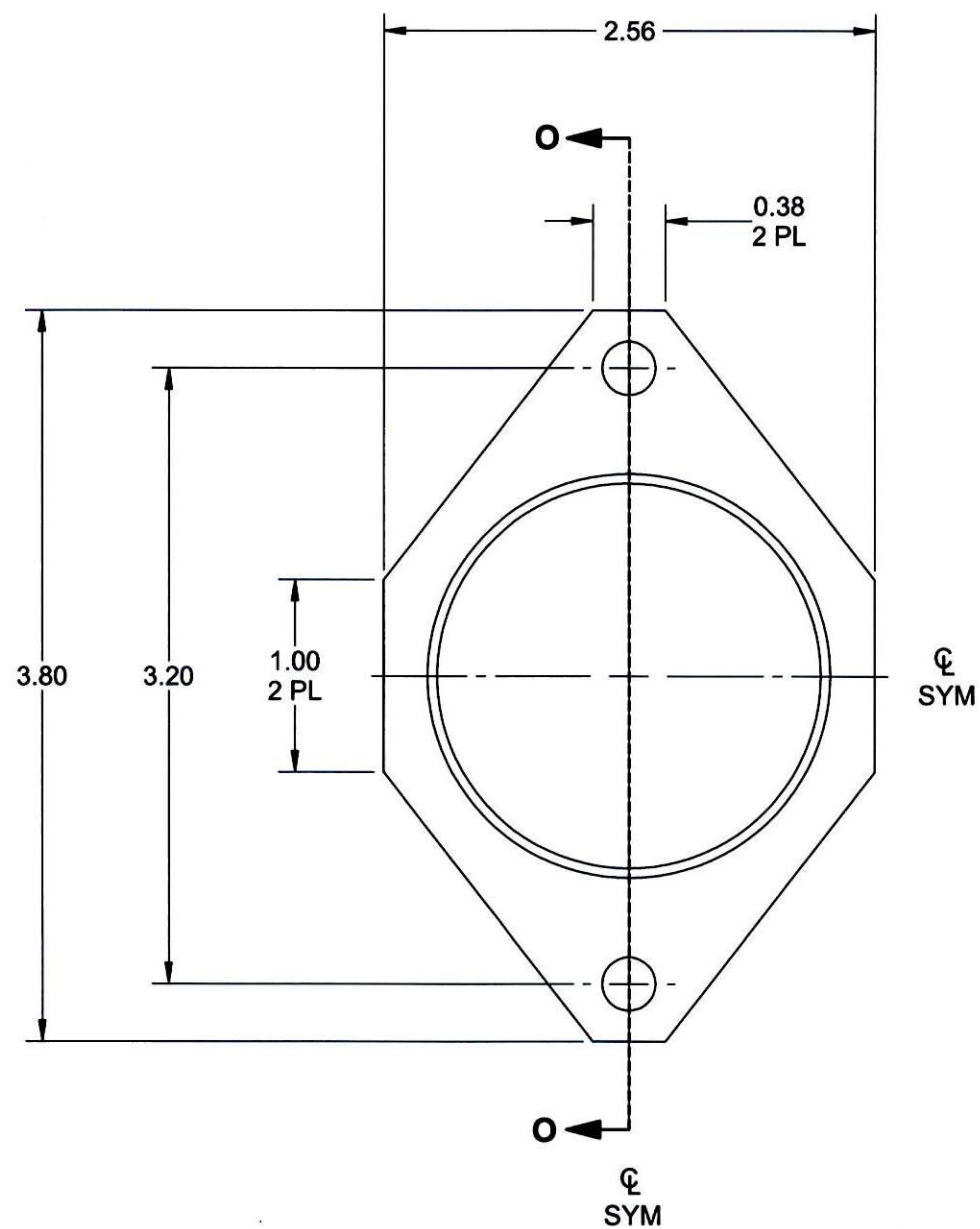


RBT18649-19-2 PLATE

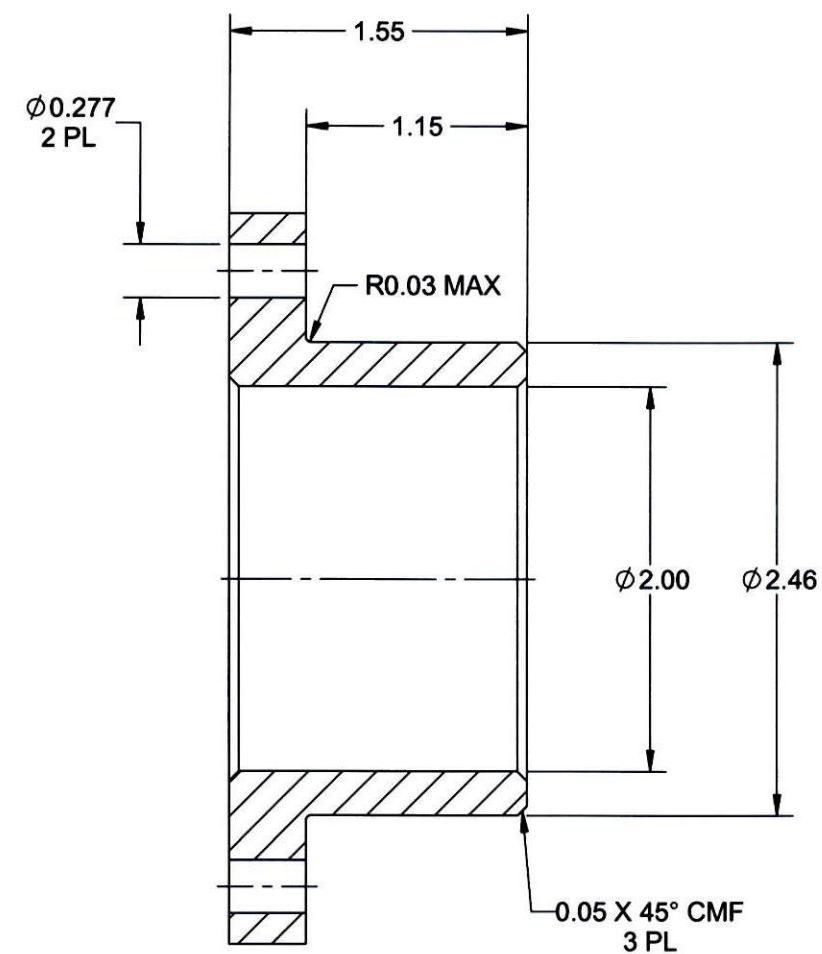


- NOTES:
- 1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

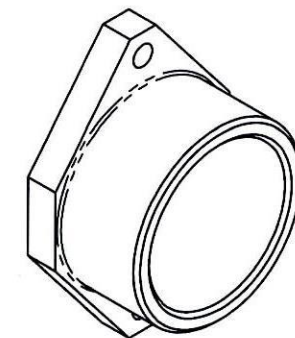
DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 33 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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RBT18649-20 WORKAID ITEM #20

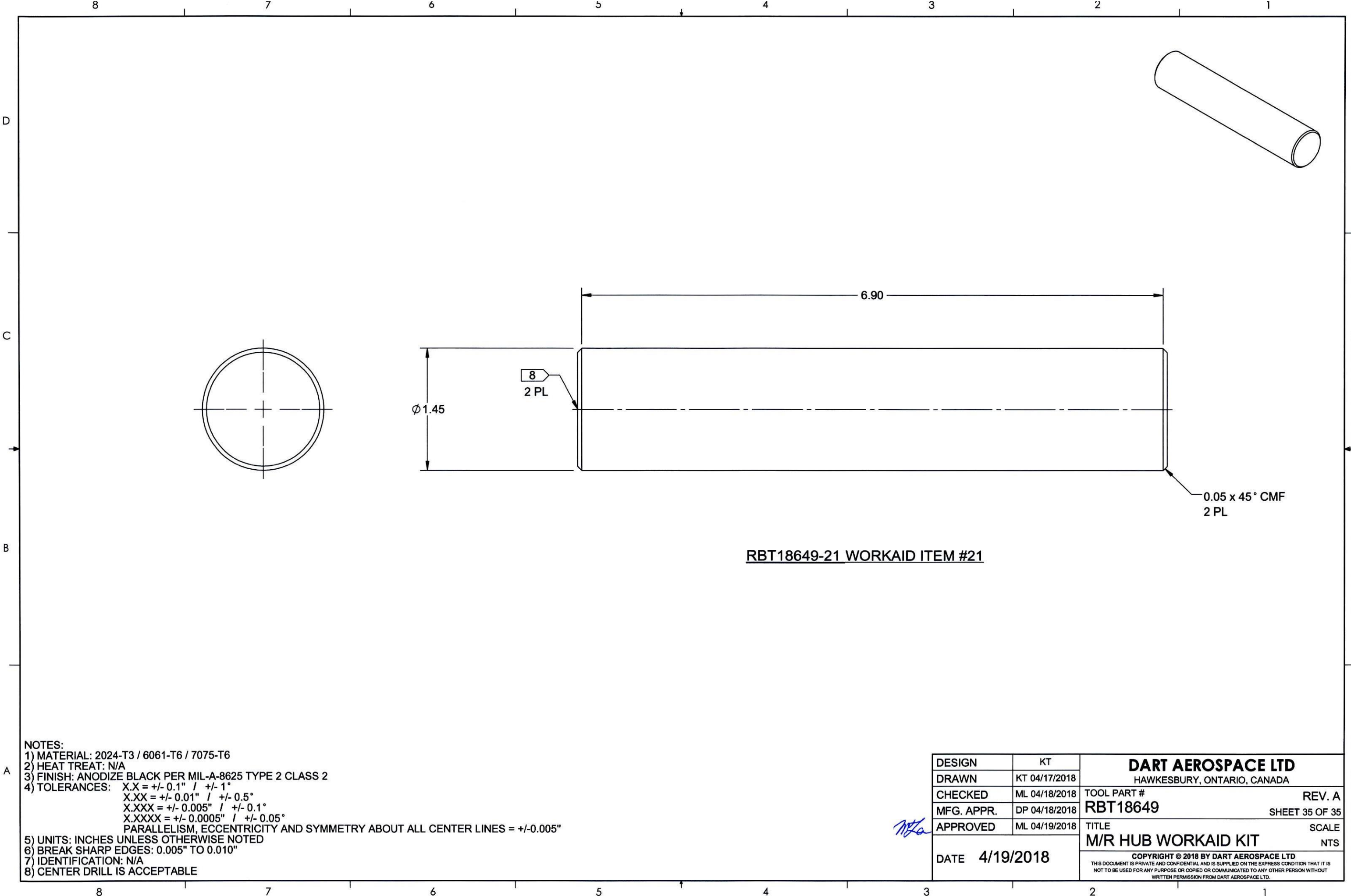


SECTION O-O



NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 04/17/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 34 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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NOTES:
1) MATERIAL: 2024-T3 / 6061-T6 / 7075-T6
2) HEAT TREAT: N/A
3) FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE 2 CLASS 2
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A
8) CENTER DRILL IS ACCEPTABLE

RBT18649-21 WORKAID ITEM #21

DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KT 04/17/2018		
CHECKED	ML 04/18/2018	TOOL PART #	REV. A
MFG. APPR.	DP 04/18/2018	RBT18649	SHEET 35 OF 35
APPROVED	ML 04/19/2018	TITLE	SCALE
DATE 4/19/2018		M/R HUB WORKAID KIT	NTS
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